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(54) **METHOD OF ASSEMBLING AN OPTICAL SENSOR ASSEMBLY FOR A CARRIAGE PRINTER**

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(73) Assignee: **Eastman Kodak Company**, Rochester, NY (US)

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(22) Filed: **Dec. 9, 2011**

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B21D 53/76 (2006.01)
B23P 17/00 (2006.01)

(52) **U.S. Cl.**
USPC **29/890.1**; 29/592.1; 29/595; 347/68; 347/70; 347/71

(58) **Field of Classification Search**
USPC 29/25.35, 595, 890.1; 347/68, 70, 71
See application file for complete search history.

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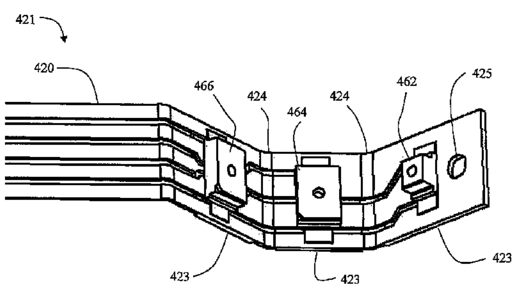
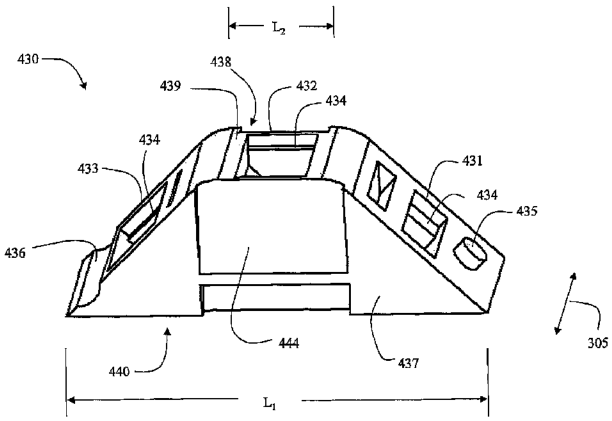
(74) *Attorney, Agent, or Firm* — Peyton C. Watkins

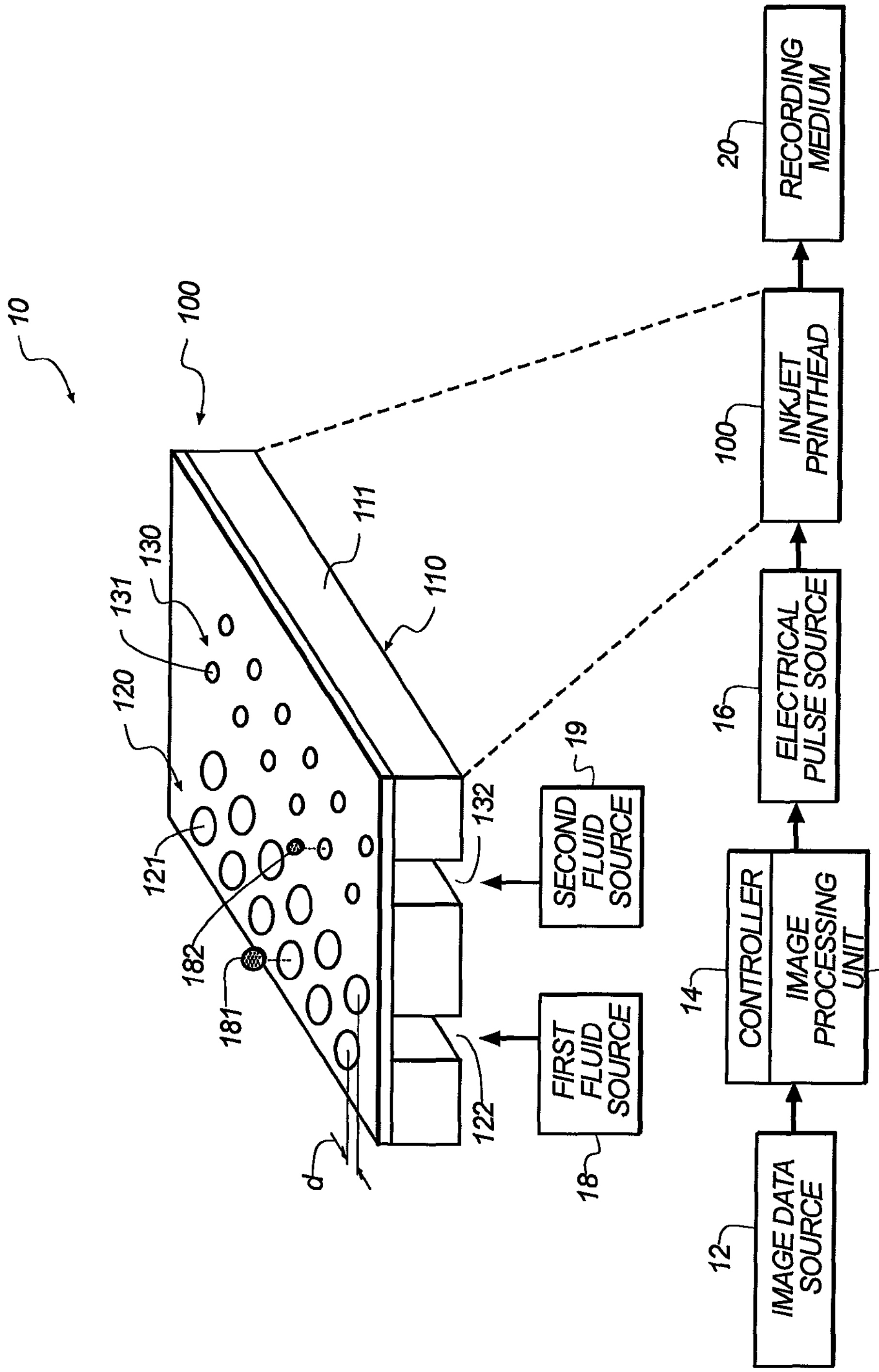
(57) **ABSTRACT**

A method of assembling an optical sensor assembly for a carriage of a carriage printer, the method includes providing a flexible circuit subassembly including a photosensor and a light source; providing a mounting member including a first cavity and a second cavity having an orientation that is different than an orientation of the first cavity; mounting the flexible circuit subassembly on the mounting member such that the photosensor is disposed in the first cavity and the light source is disposed in the second cavity; and affixing the mounting member to an outer housing, wherein a connector end of the flexible circuit subassembly extends outwardly from the mounting member and the outer housing.

9 Claims, 21 Drawing Sheets



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SECOND FLUID SOURCE
FIRST FLUID SOURCE
18
IMAGE DATA SOURCE
12
CONTROLLER
14
IMAGE PROCESSING UNIT
15
ELECTRICAL PULSE SOURCE
16
INKJET PRINTHEAD
100
RECORDING MEDIUM
20

FIG. 1

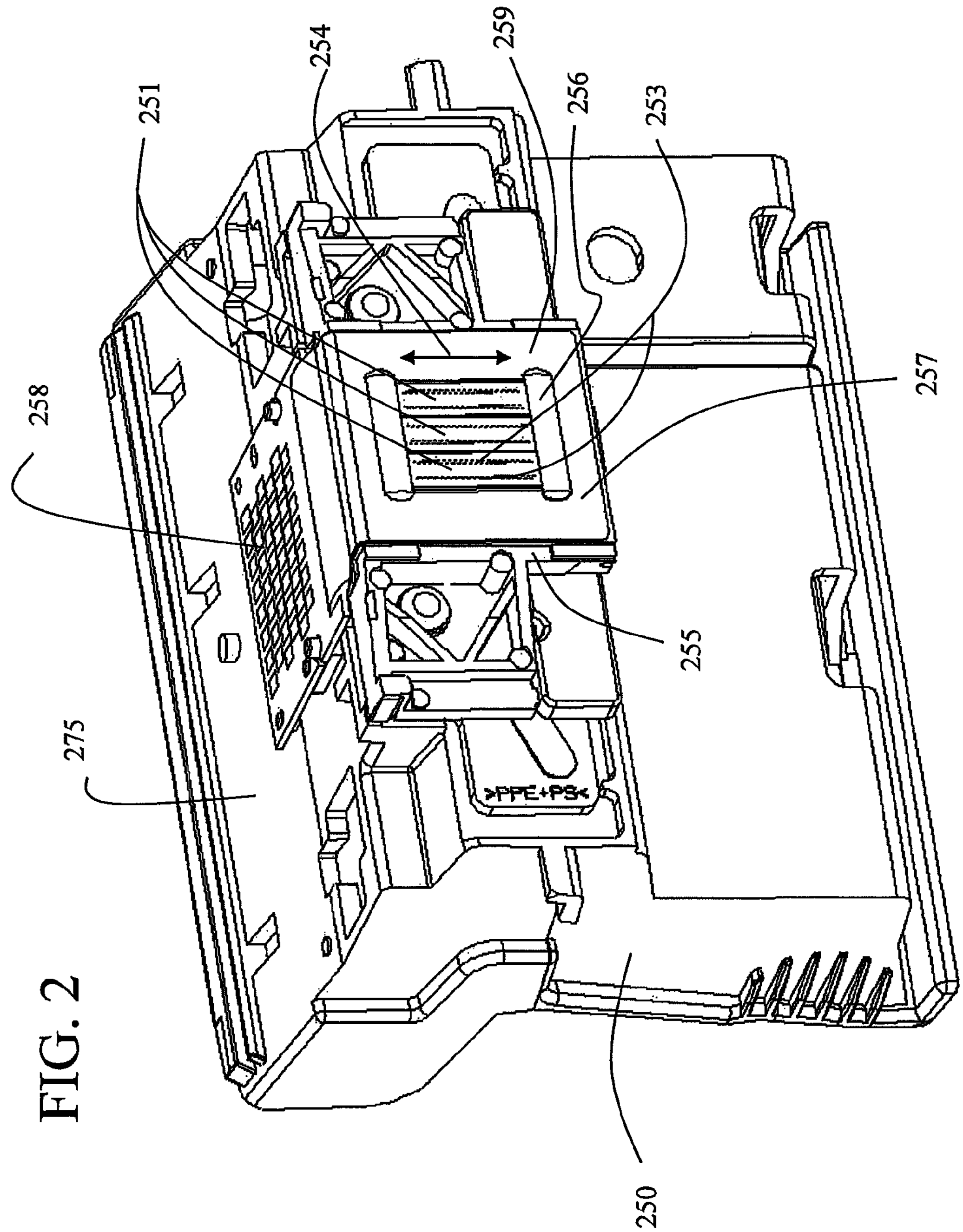
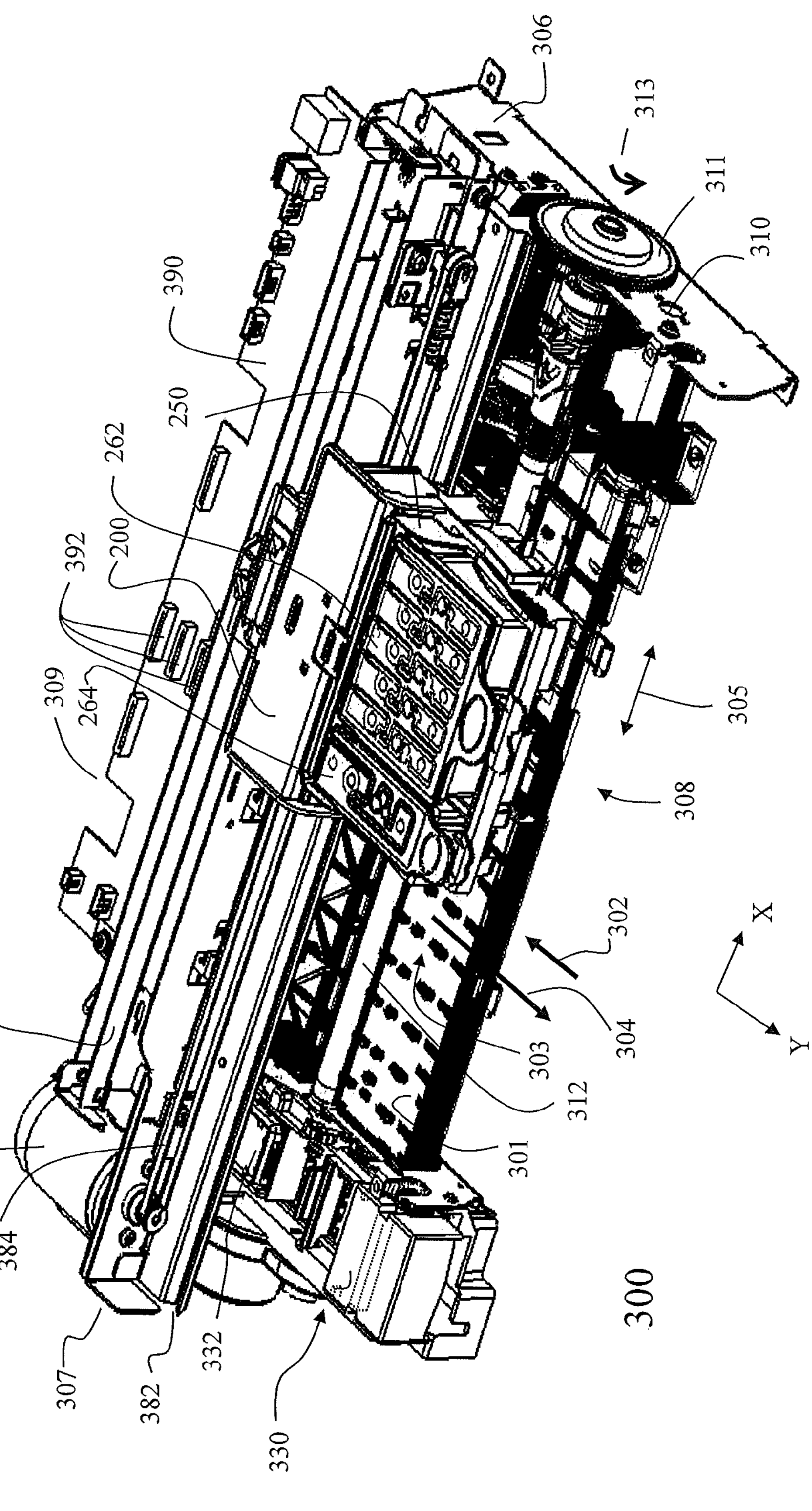


FIG. 2

FIG. 3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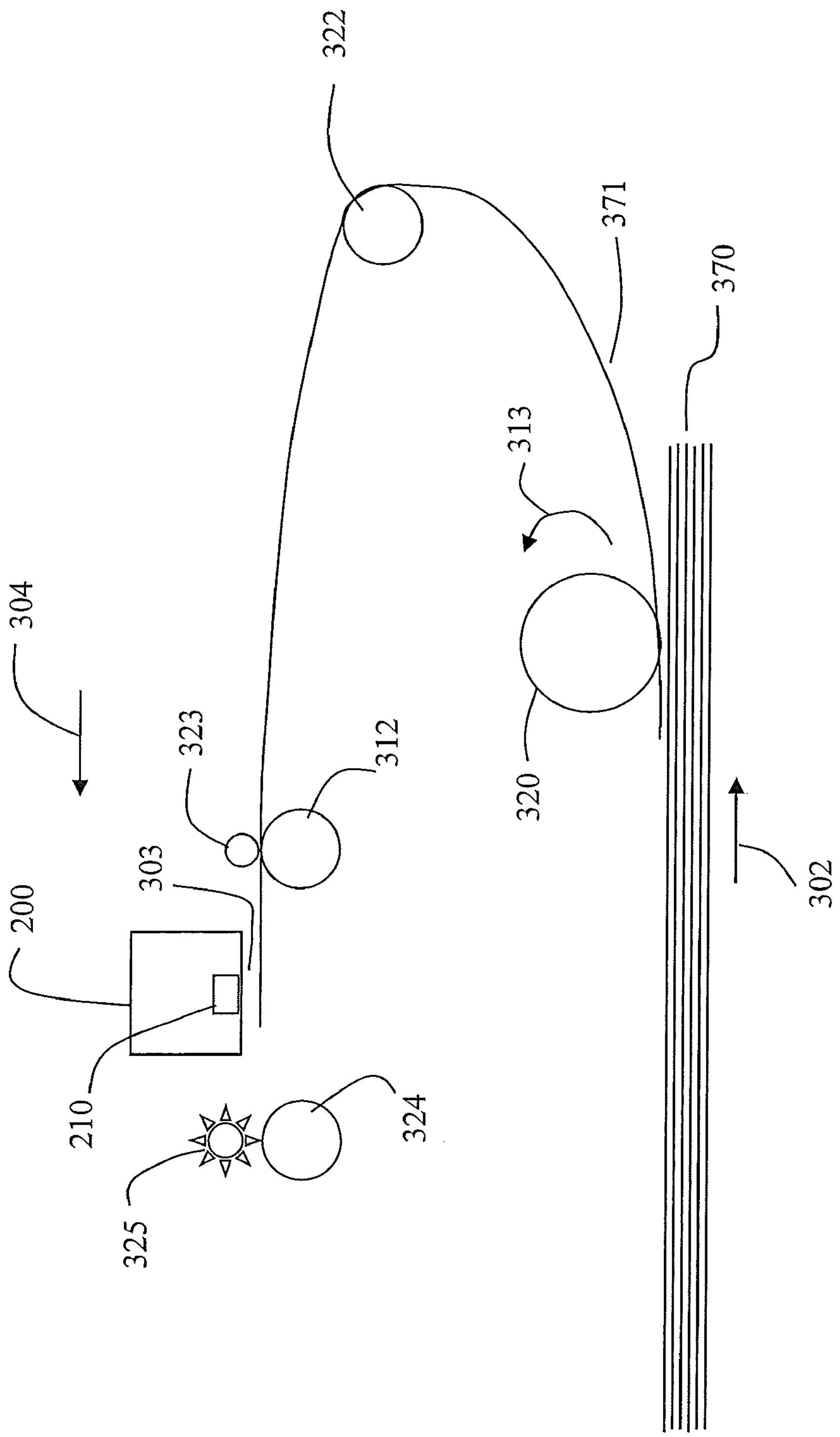

FIG. 4

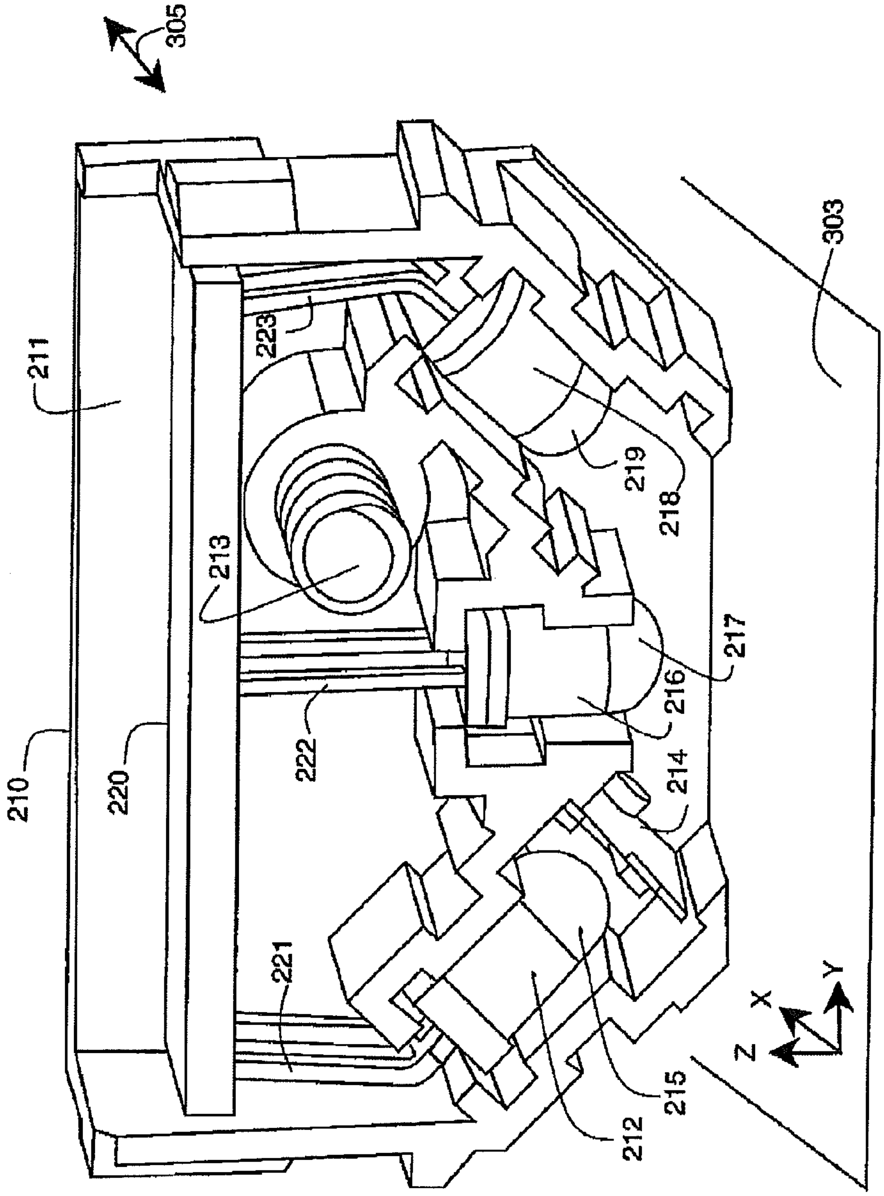

FIG. 5 Prior Art

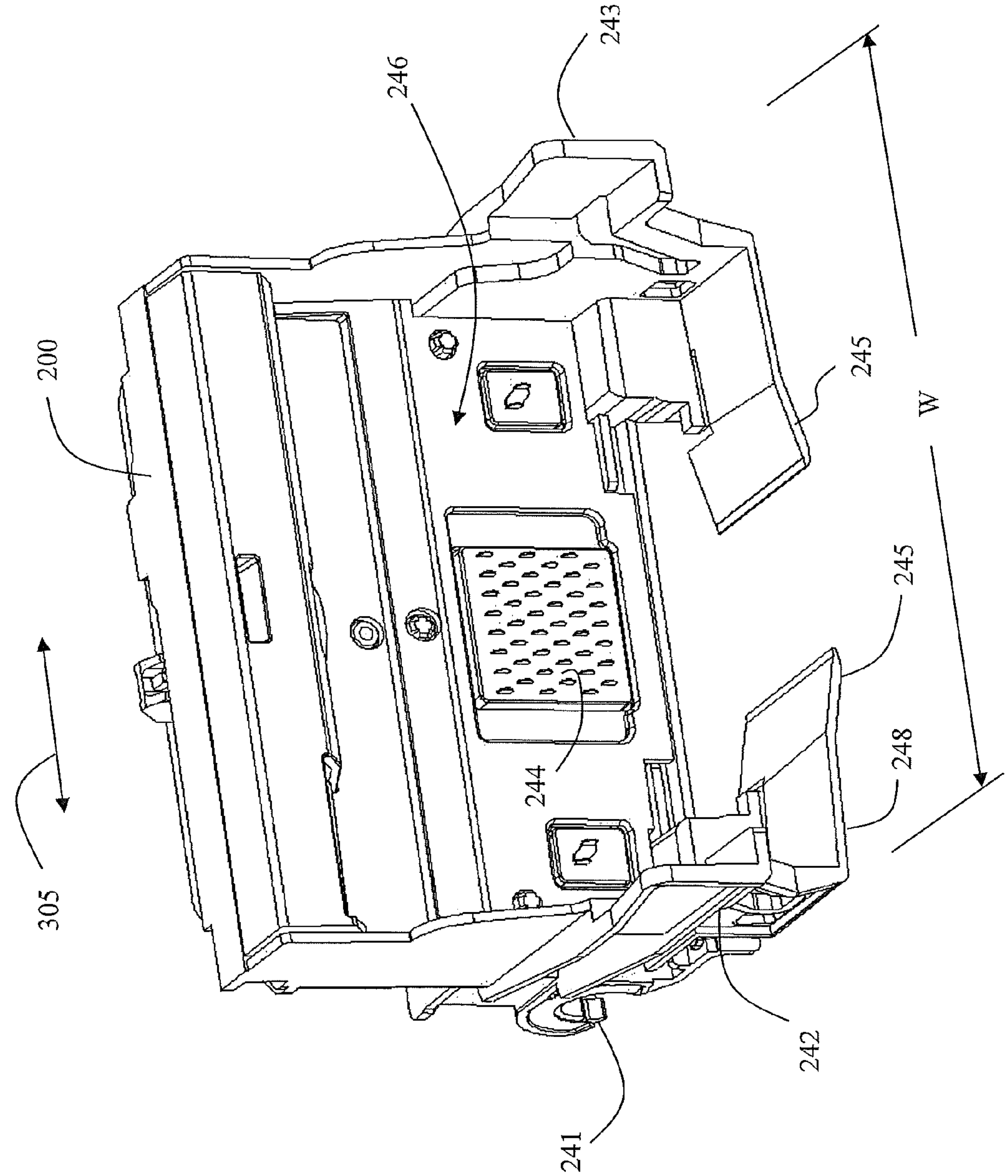

FIG. 6

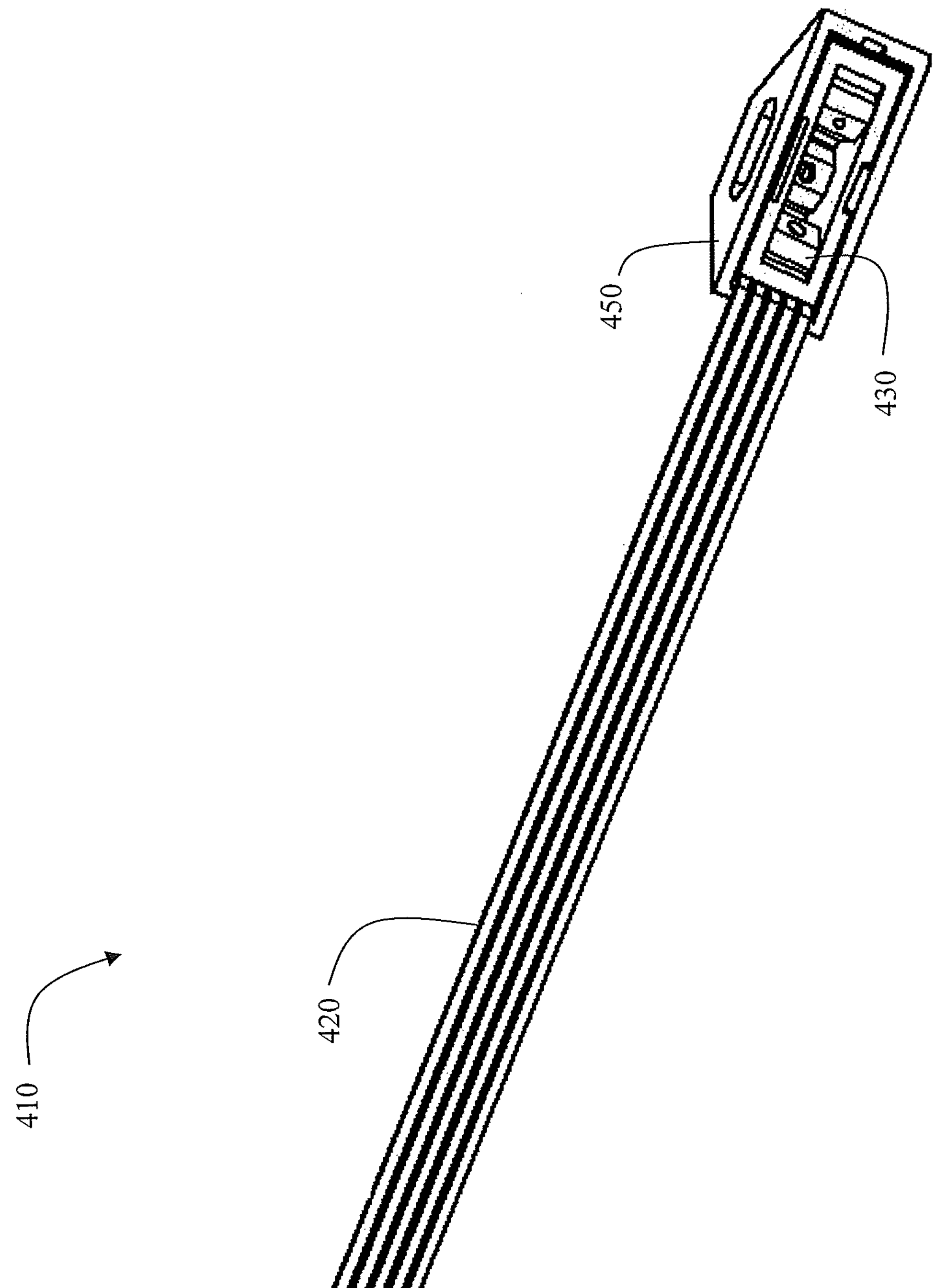

FIG. 7

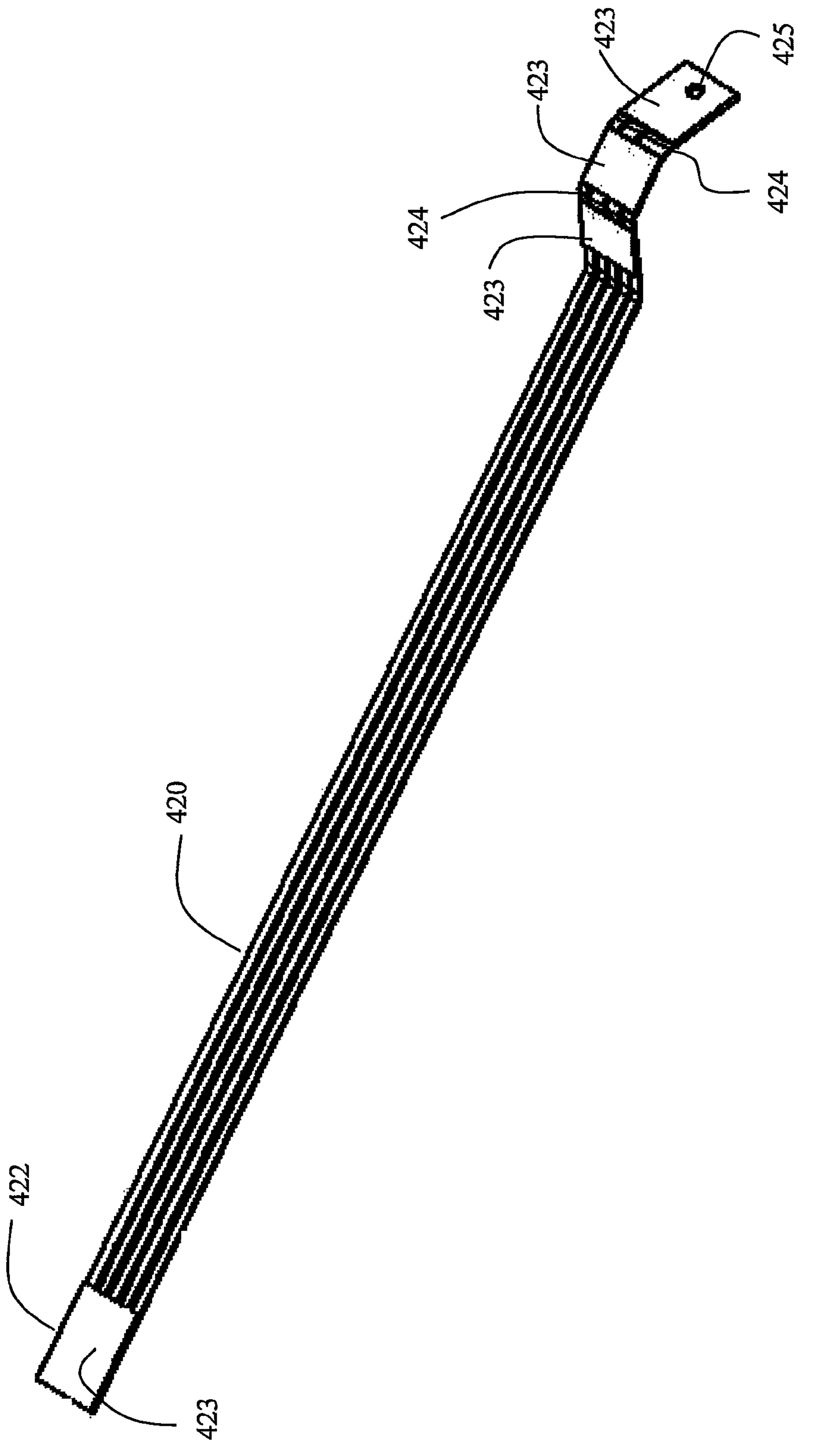

FIG. 8

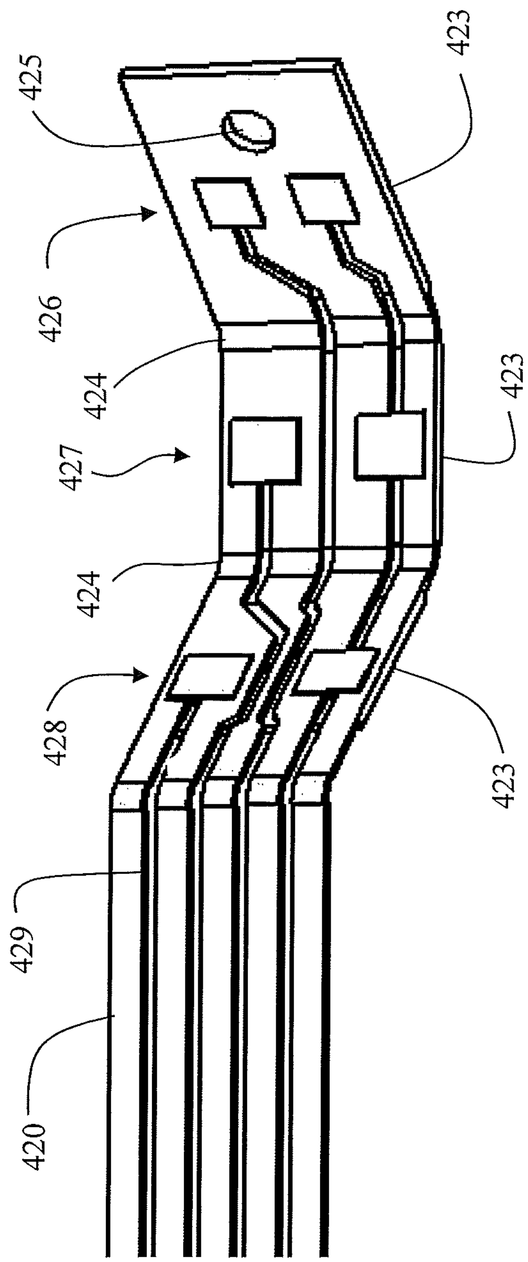

FIG. 9

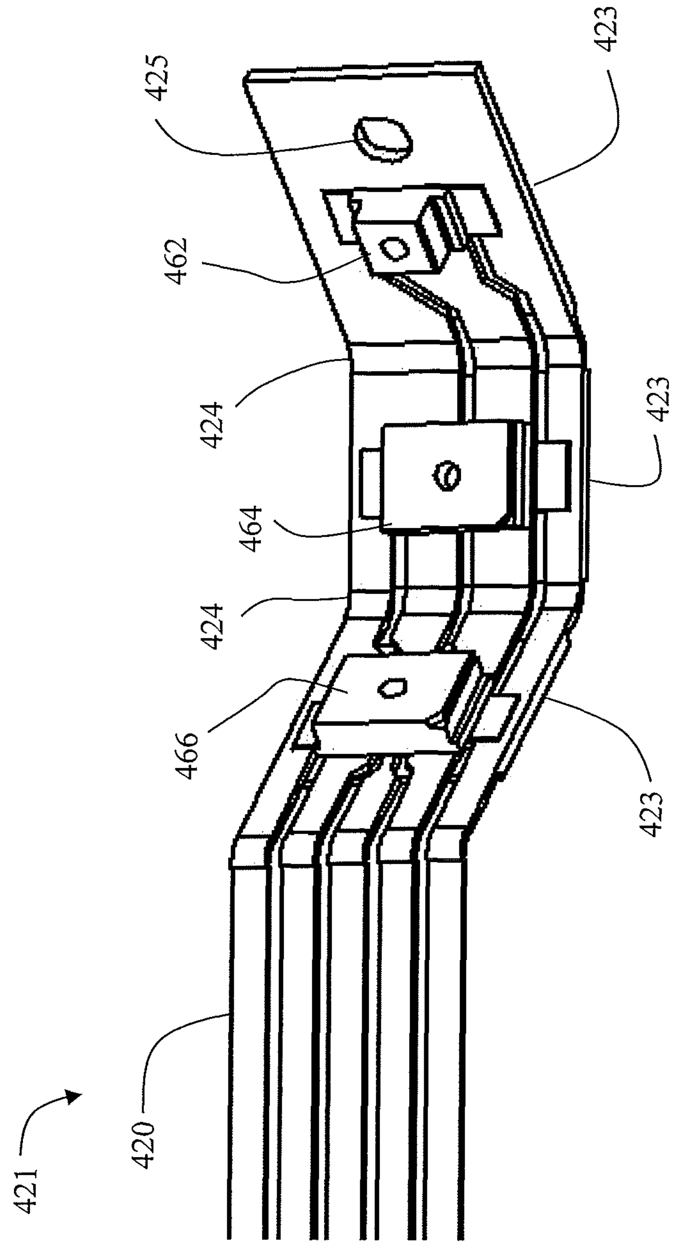

FIG. 10

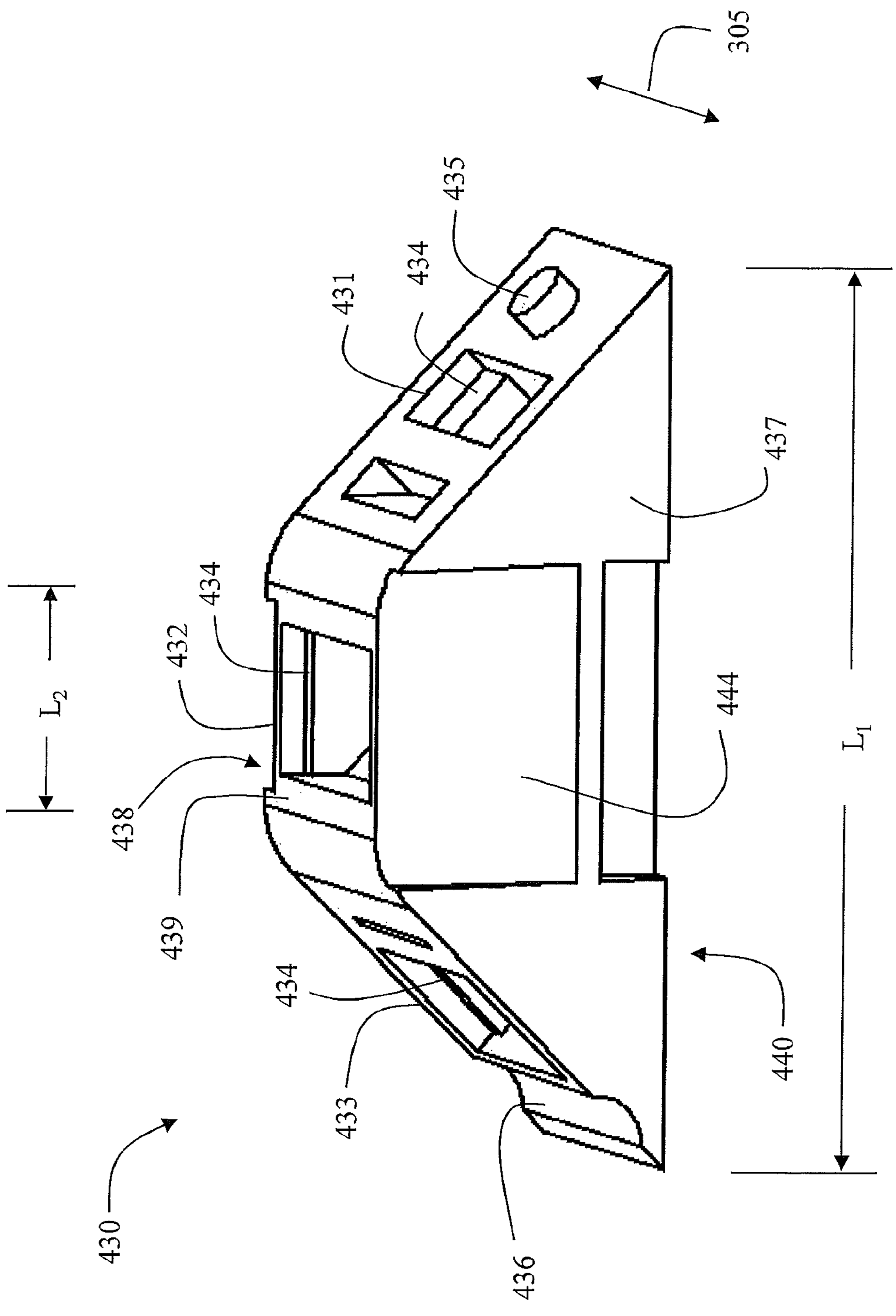

FIG. 11

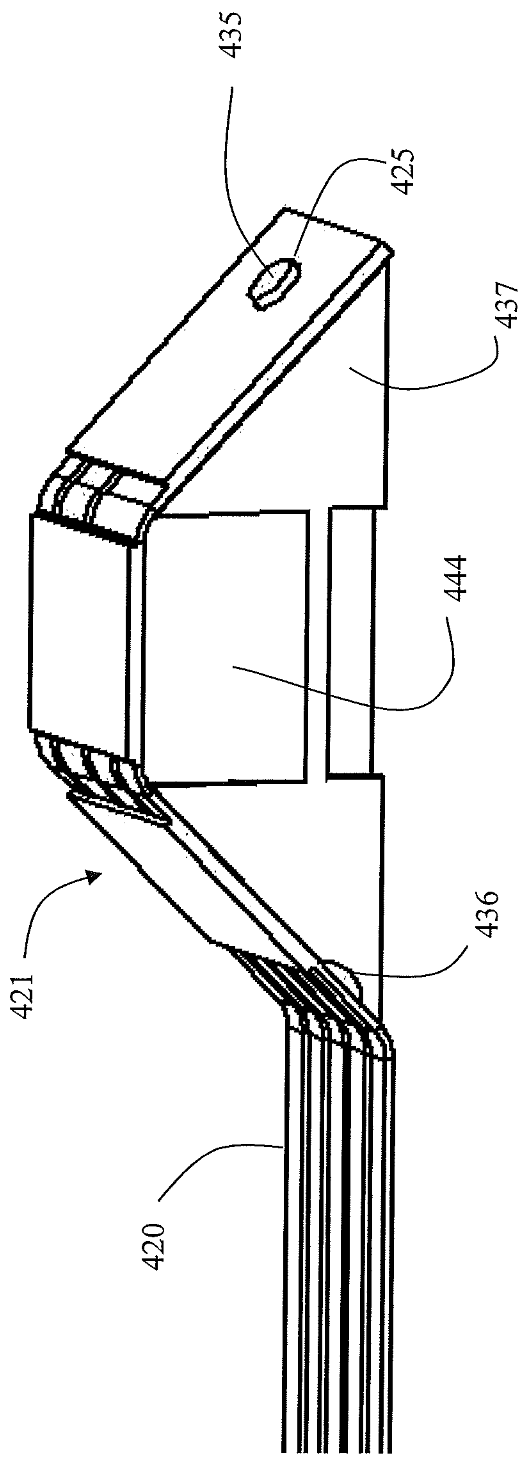

FIG. 12

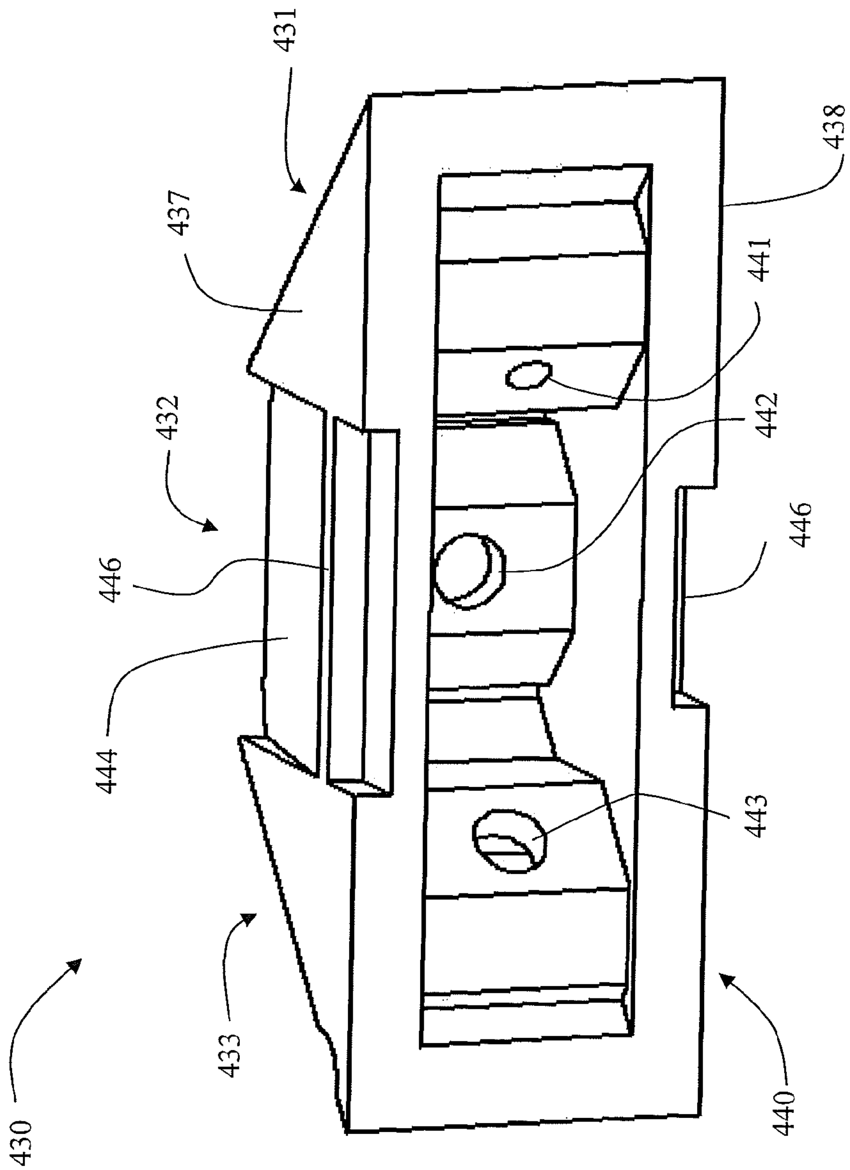

FIG. 13

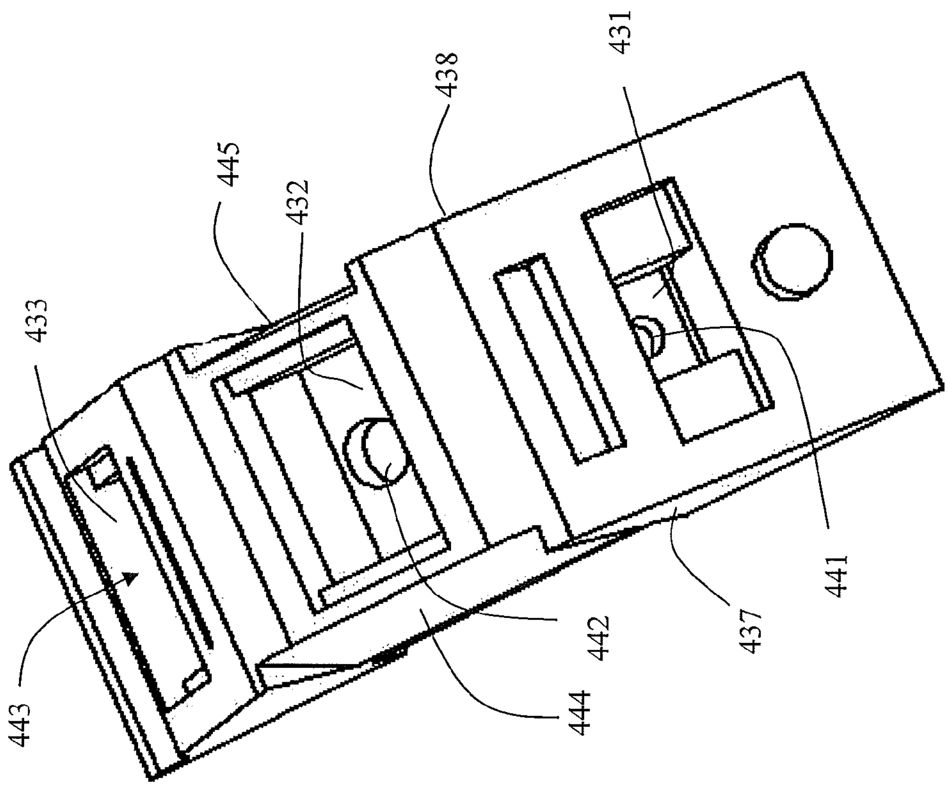

FIG. 14

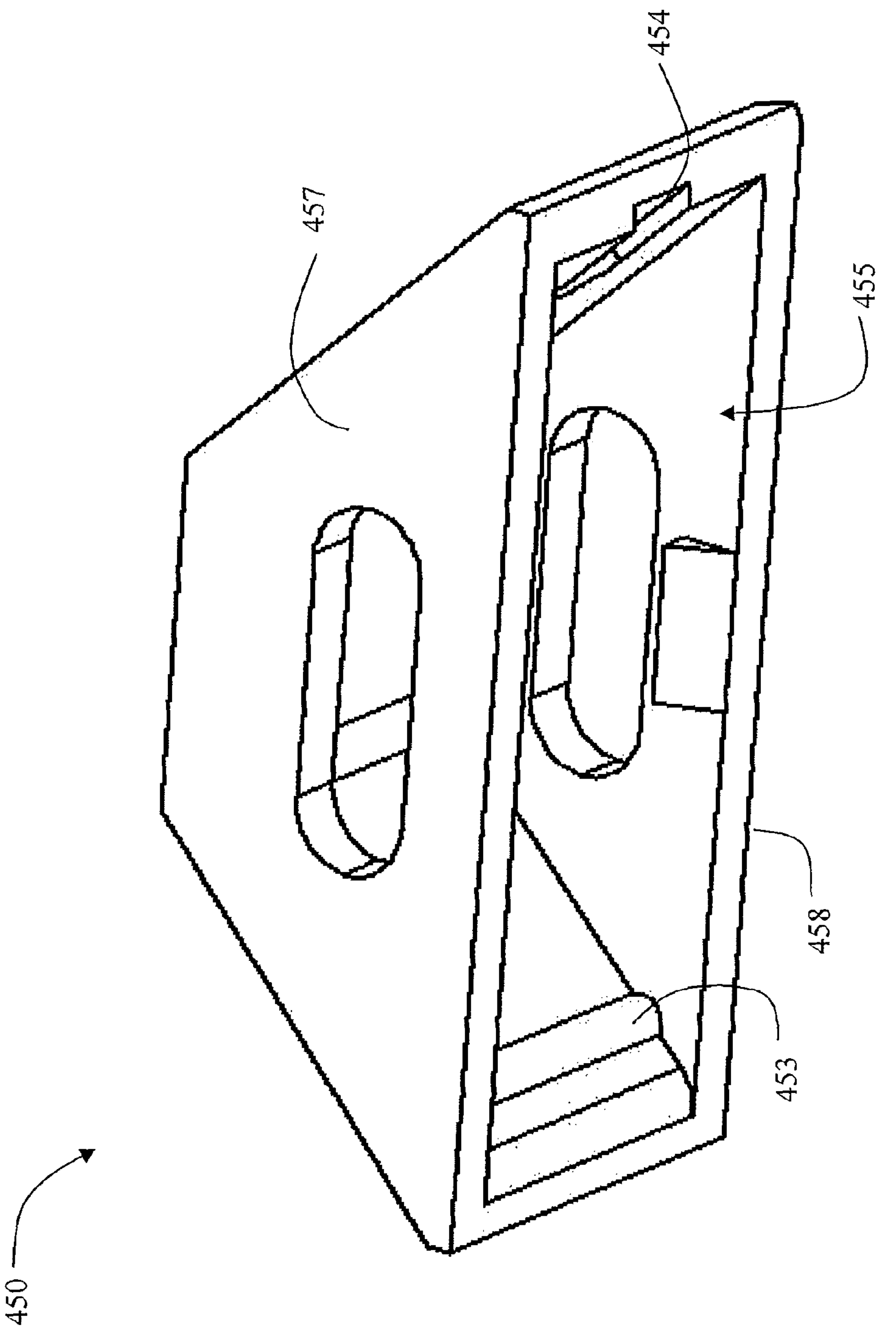

FIG. 15

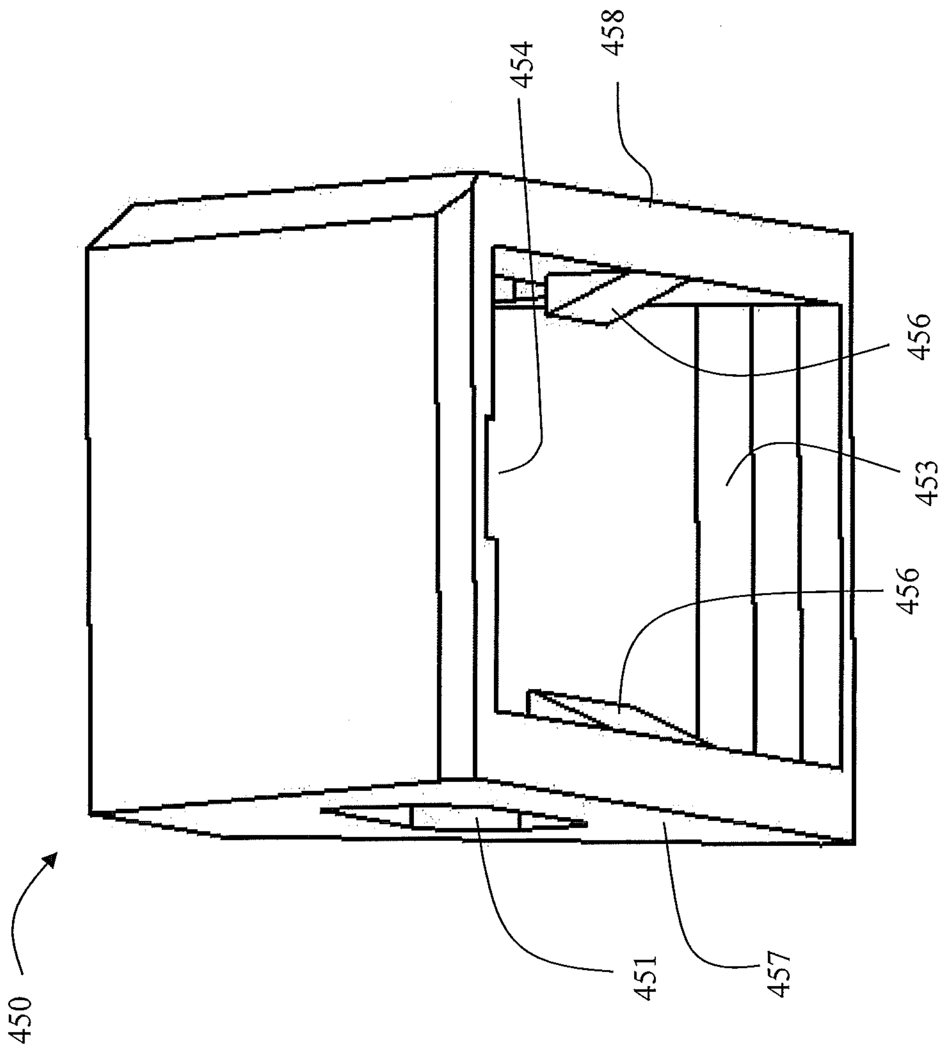

FIG. 16

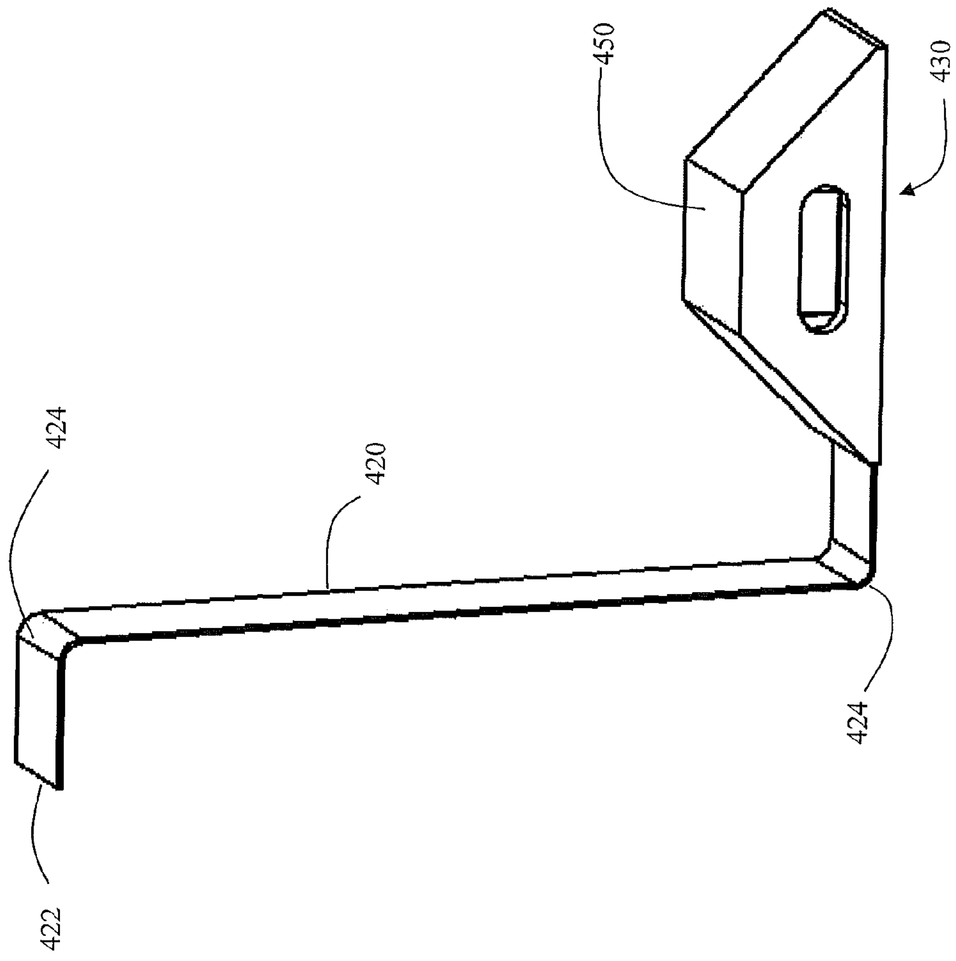

FIG. 17

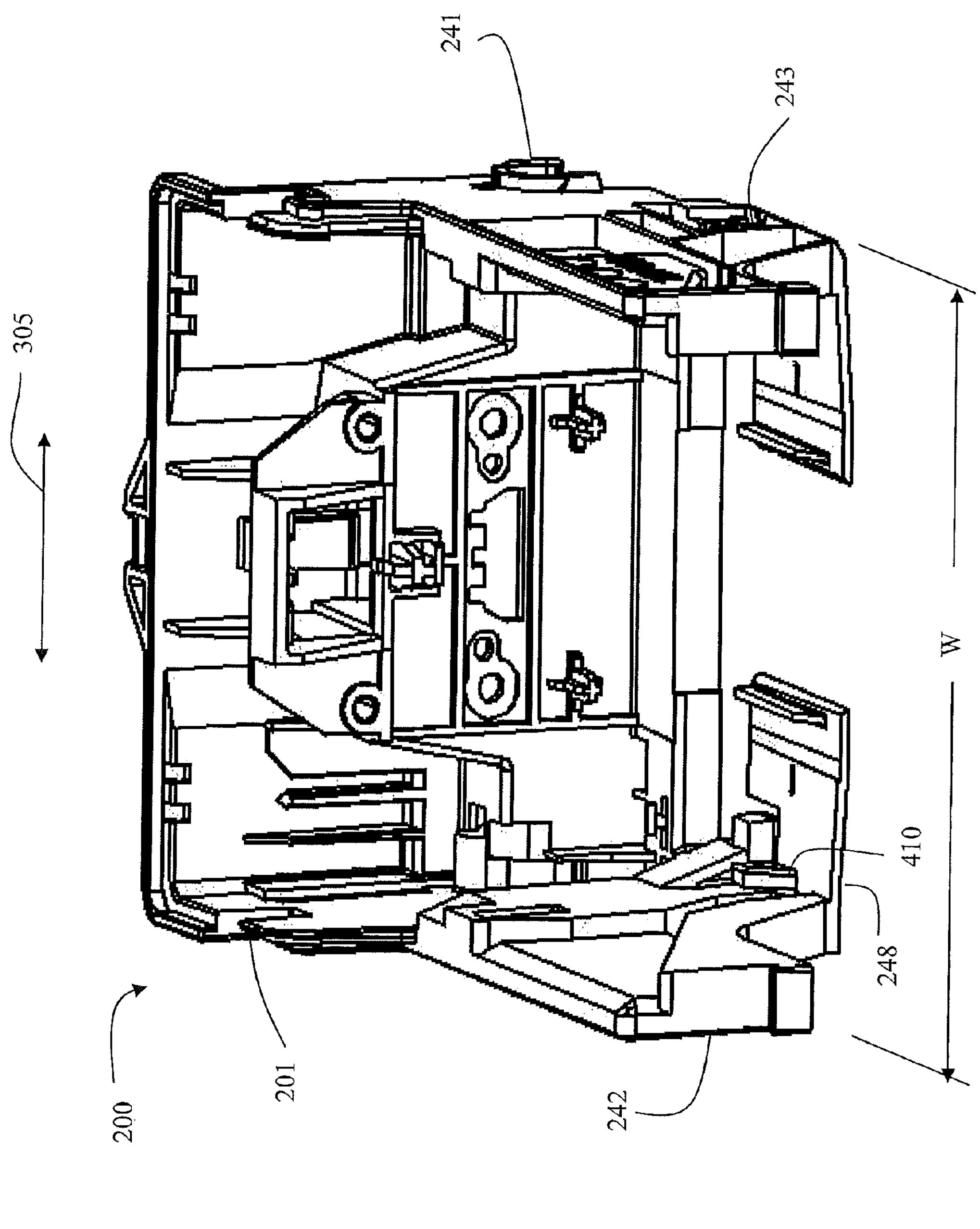

FIG. 18

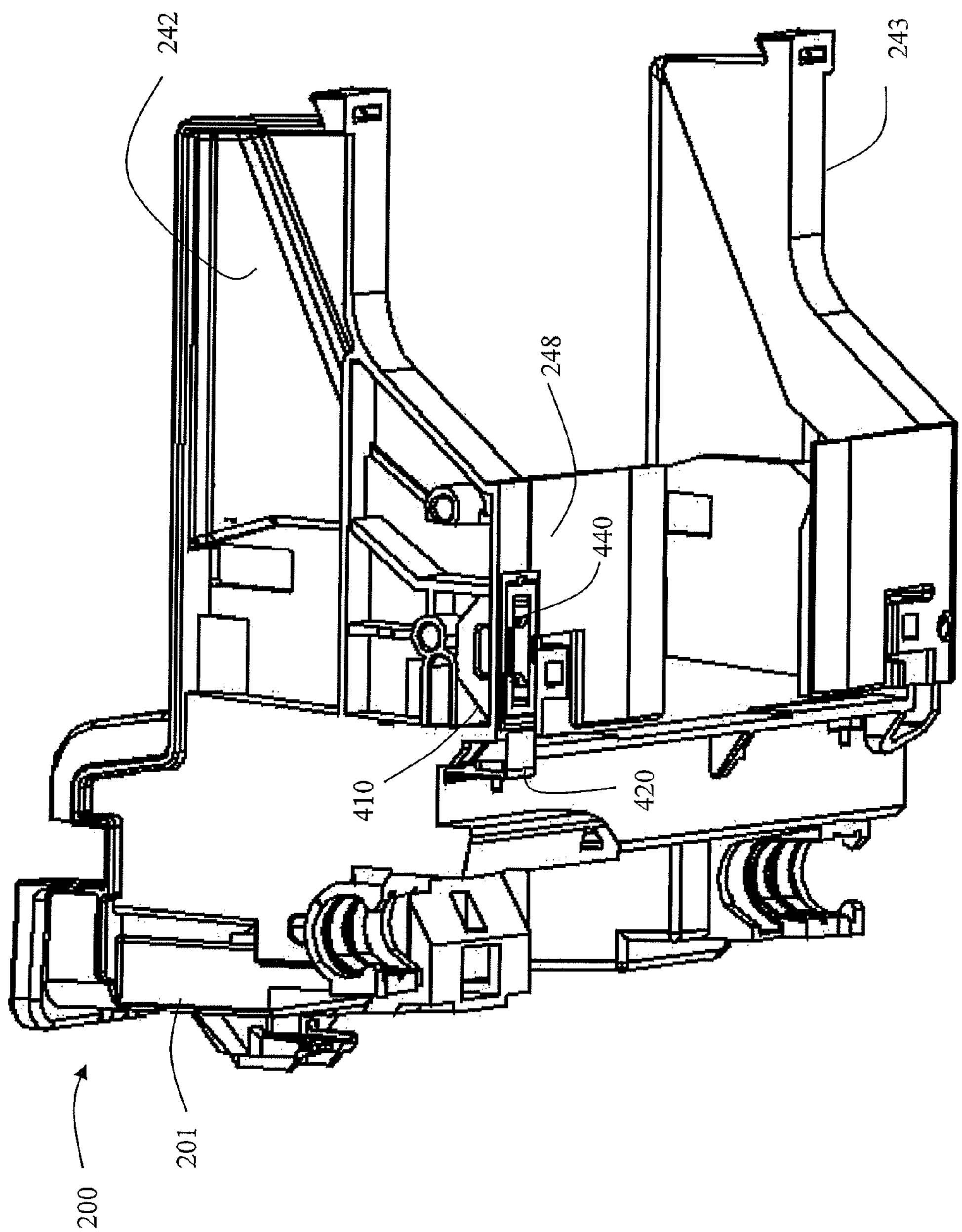

FIG. 19

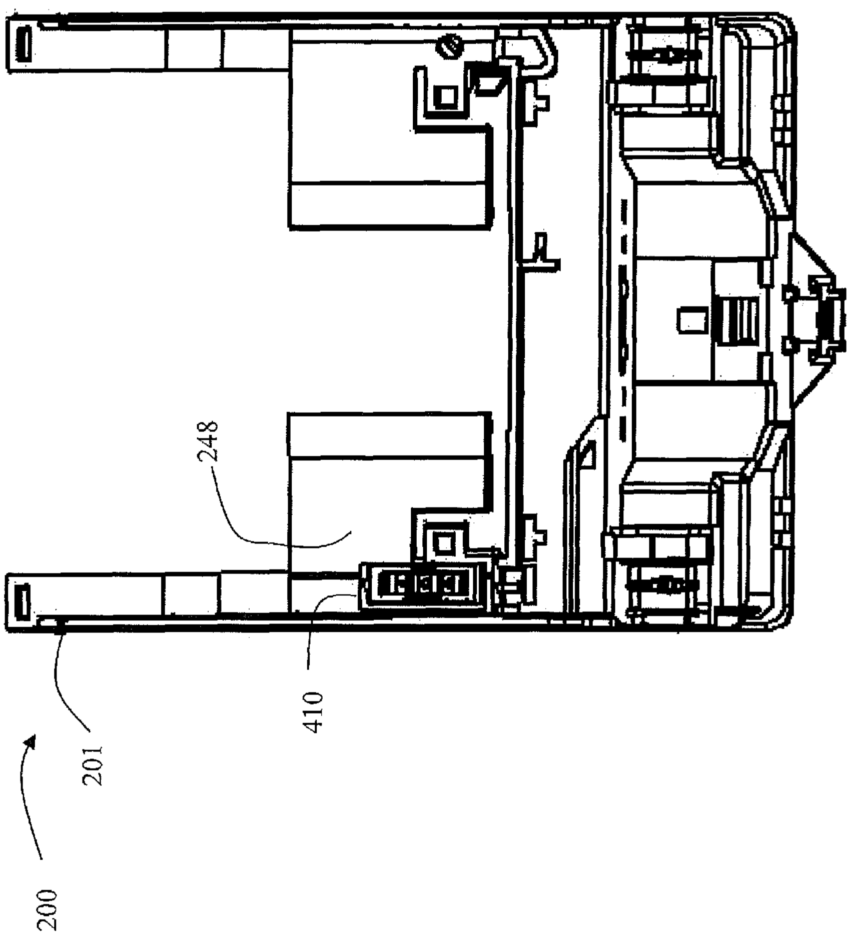

FIG. 20

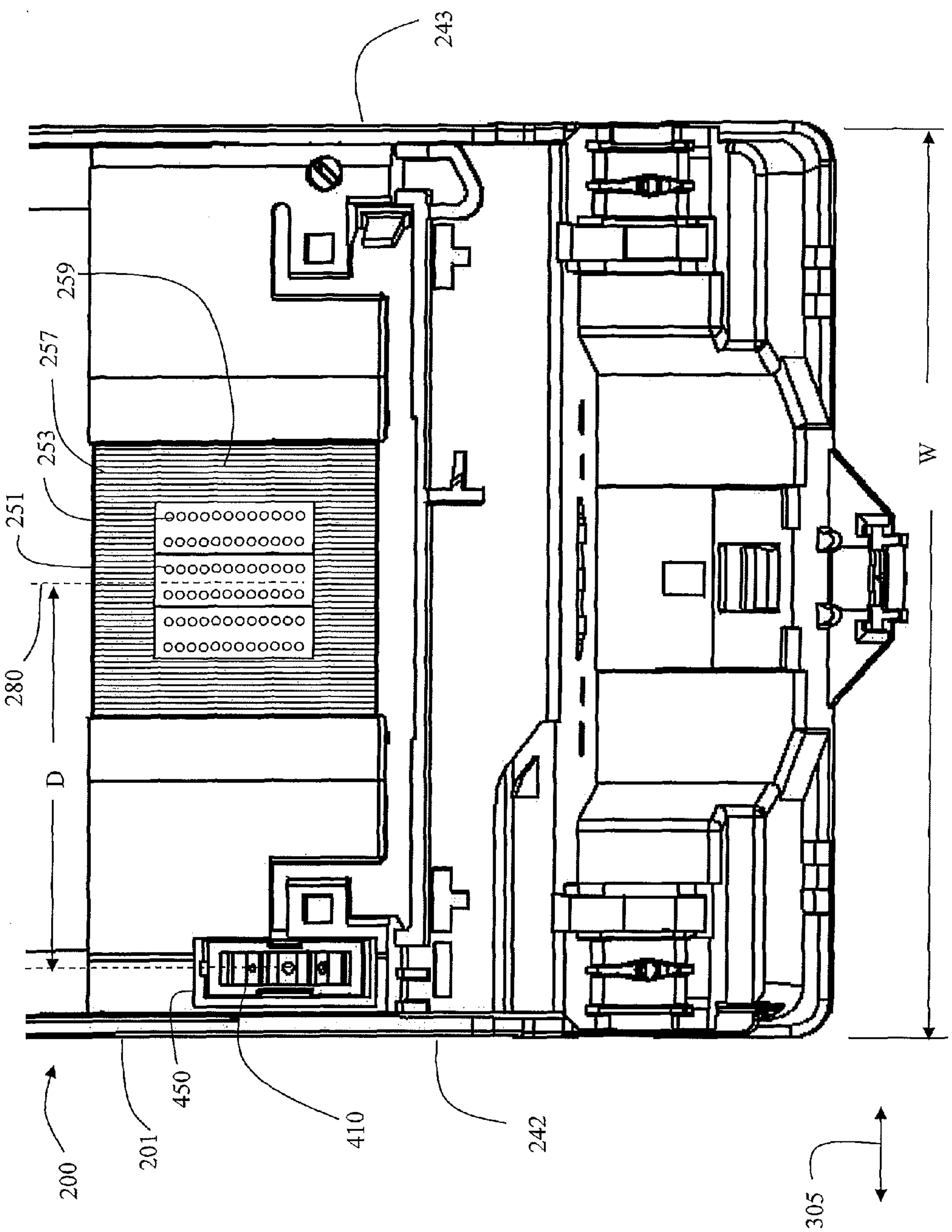

FIG. 21

METHOD OF ASSEMBLING AN OPTICAL SENSOR ASSEMBLY FOR A CARRIAGE PRINTER

CROSS REFERENCE TO RELATED APPLICATION

Reference is made to commonly assigned, co-pending U.S. patent application Ser. No. 13/315,838, concurrently filed herewith, entitled "Carriage Printer With Optical Sensor Assembly" by Juan M. Jimenez et al, the disclosure of which is herein incorporated by reference.

FIELD OF THE INVENTION

This invention relates generally to the field of carriage printers, and in particular to a carriage-mounted optical sensor assembly configured to obtain information regarding a printing side of the recording medium.

BACKGROUND OF THE INVENTION

A common type of printer architecture is a carriage printer, where a printhead array of marking elements is somewhat smaller than an extent of a region of interest for printing on a recording medium and a printhead is mounted on a carriage. In a carriage printer, the recording medium is advanced a given distance along a media advance direction and then stopped. While the recording medium is stopped, the printhead is moved by the carriage in a carriage scan direction that is substantially perpendicular to the media advance direction as marks are controllably made by marking elements. After the printhead has printed a swath of an image while traversing the recording medium, the recording medium is advanced, the carriage direction of motion is reversed, and the image is formed swath by swath.

One example of a carriage printer is an inkjet printer. An inkjet printing system typically includes one or more printheads and their corresponding ink supplies. Each printhead includes an ink inlet that is connected to its ink supply and an array of drop ejectors that function as marking elements, each ejector consisting of an ink pressurization chamber, an ejecting actuator and a nozzle through which droplets of ink are ejected. The ejecting actuator can be one of various types, including a heater that vaporizes some of the ink in a pressurization chamber in order to propel a droplet out of an orifice, or a piezoelectric device which changes the wall geometry of the chamber in order to generate a pressure wave that ejects a droplet. The droplets are typically directed toward paper or other recording medium in order to produce an image according to image data that is converted into electronic firing pulses for the drop ejectors as the printhead is moved relative to the recording medium.

In order to produce high quality images, it is helpful to provide information to the printer controller electronics regarding the printing side of the recording medium and the characteristics of the marks printed on the recording medium by the printhead. Information about the recording medium itself can include whether it is a glossy or matte-finish paper. Information about the marks printed on the recording medium can include relative alignment between marks of different colors, angular misorientation of the printhead relative to the direction of relative motion of the recording medium, or relative alignment of marks between left to right and right to left passes in a carriage printer, or missing marks corresponding to defective portions of the printhead, such as bad nozzles in an inkjet printhead. Using the information

from the optical sensor, the printer controller is designed to control the printing process to optimize printing quality by using appropriate print modes for the detected media type, by correcting for various types of misalignments and by compensating for defective portions of the printhead.

It is known in the prior art to attach an optical sensor assembly to the printhead carriage of a carriage printer. See for example U.S. Pat. Nos. 5,170,047; 5,905,512; 5,975,674; 6,036,298; 6,172,690; 6,322,192; 6,400,099; 6,623,096; 6,764,158; 6,905,187 and 7,800,089. Such an optical sensor assembly can be called a carriage sensor. In the same way that the printhead can mark on all regions of the paper by the back and forth motion of the carriage and by the advancing of the recording medium between passes of the carriage, it is desirable for the carriage sensor to be able to provide optical measurements, such as optical reflectance, for all regions of the paper. A carriage sensor assembly typically includes one or more photosensors and one or more light sources, such as LED's, mounted such that the emitted light is reflected off the printing side of the recording medium, and the reflected light is received in the one or more photosensors. LEDs and photosensors can be oriented relative to each other such that the photosensor receives specular reflections of light emitted from an LED (i.e. light reflected from the recording medium at the same angle as the incident angle relative to the normal to the nominal plane of the recording medium) or diffuse reflections of light emitted from an LED (i.e. light reflected from the recording medium at a different angle than the angle of incidence). A carriage sensor such as that described in U.S. Pat. No. 7,800,089, which is incorporated by reference herein in its entirety, works well for detecting surface roughness of the recording medium, side edges of the recording medium, and alignment marks and test patterns printed on the recording medium. However, a more compact carriage sensor is needed for printers having a small footprint. It has been found that for some carriage printers having a reduced width that a carriage sensor such as the one described in U.S. Pat. No. 7,800,089 cannot detect both side edges of the widest compatible recording medium without interfering with other portions of the printer. In addition, a more economical carriage sensor is needed, especially for low cost printers. It is also desirable to have a carriage sensor assembly that is more efficient than carriage sensors of the prior art.

SUMMARY OF THE INVENTION

The present invention is directed to overcoming one or more of the problems set forth above. Briefly summarized, according to one aspect of the invention, the invention resides in a method of assembling an optical sensor assembly for a carriage of a carriage printer, the method includes providing a flexible circuit subassembly including a photosensor and a light source; providing a mounting member including a first cavity and a second cavity having an orientation that is different than an orientation of the first cavity; mounting the flexible circuit subassembly on the mounting member such that the photosensor is disposed in the first cavity and the light source is disposed in the second cavity; and affixing the mounting member to an outer housing, wherein a connector end of the flexible circuit subassembly extends outwardly from the mounting member and the outer housing.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. **1** is a schematic representation of an inkjet printer system;

FIG. **2** is a perspective of a portion of a printhead;

FIG. **3** is a perspective of a portion of a carriage printer;

FIG. **4** is a schematic side view of an exemplary paper path in a carriage printer;

FIG. **5** is a perspective of prior art carriage sensor assembly; FIG. **6** is a perspective of a carriage;

FIG. **7** is perspective of an embodiment of an optical sensor assembly;

FIG. **8** is a perspective of a flexible circuit included in the embodiment of FIG. **7**;

FIG. **9** is a close-up perspective of a portion of the flexible circuit of FIG. **8**;

FIG. **10** is a perspective that is similar to FIG. **9**, but also including a photosensor and two light sources;

FIG. **11** is a perspective of a mounting member included in the embodiment of FIG. **7**;

FIG. **12** is a perspective similar to that of FIG. **11**, but also including the flexible circuit of FIG. **8**;

FIG. **13** is a bottom perspective of the mounting member of FIG. **11**;

FIG. **14** is a top perspective of the mounting member of FIG. **11**;

FIG. **15** is a perspective of an outer housing included in the embodiment of FIG. **7**;

FIG. **16** is a bottom end perspective of the outer housing of FIG. **15**;

FIG. **17** is a perspective of an embodiment of an optical sensor assembly;

FIG. **18** is a perspective of an embodiment of a carriage including an optical sensor assembly;

FIG. **19** is a bottom perspective of the carriage of FIG. **18**;

FIG. **20** is a bottom view of the carriage of FIG. **18**; and

FIG. **21** is an enlarged bottom view of the carriage of FIG. **18** and also including a printhead face.

DETAILED DESCRIPTION OF THE INVENTION

Referring to FIG. **1**, a schematic representation of an inkjet printer system **10** is shown, for its usefulness with the present invention and is fully described in U.S. Pat. No. 7,350,902, and is incorporated by reference herein in its entirety. Inkjet printer system **10** includes an image data source **12**, which provides data signals that are interpreted by a controller **14** as being commands to eject drops. Controller **14** includes an image processing unit **15** for rendering images for printing, and outputs signals to an electrical pulse source **16** of electrical energy pulses that are inputted to an inkjet printhead **100**, which includes at least one inkjet printhead die **110**.

In the example shown in FIG. **1**, there are two nozzle arrays **120**, **130** disposed at a surface of inkjet printhead die **110**. Nozzles **121** in the first nozzle array **120** have a larger opening area than nozzles **131** in the second nozzle array **130**. In this example, each of the two nozzle arrays **120**, **130** has two staggered rows of nozzles, each row having a nozzle density of 600 per inch. The effective nozzle density then in each array is 1200 per inch (i.e. d=1/1200 inch in FIG. **1**). If pixels on a recording medium **20** were sequentially numbered along a paper advance direction, the nozzles from one row of an array would print the odd numbered pixels, while the nozzles from the other row of the array would print the even numbered pixels.

In fluid communication with each nozzle array **120**, **130** is a corresponding ink delivery pathway **122**, **132**. Ink delivery pathway **122** is in fluid communication with the first nozzle array **120**, and ink delivery pathway **132** is in fluid communication with the second nozzle array **130**. Portions of ink delivery pathways **122** and **132** are shown in FIG. **1** as openings through a printhead die substrate **111**. One or more inkjet printhead die **110** will be included in inkjet printhead **100**, but for greater clarity only one inkjet printhead die **110** is shown in FIG. **1**. The printhead die **110** are arranged on a support member as discussed below relative to FIG. **2**. In FIG. **1**, a first ink source **18** supplies ink to first nozzle array **120** via ink delivery pathway **122**, and a second ink source **19** supplies ink to second nozzle array **130** via ink delivery pathway **132**. Although distinct ink sources **18** and **19** are shown, in some applications it can be beneficial to have a single ink source supplying ink to both the first nozzle array **120** and the second nozzle array **130** via ink delivery pathways **122** and **132** respectively. Also, in some embodiments, fewer than two or more than two nozzle arrays **120**, **130** can be included on printhead die **110**. In some embodiments, all nozzles on inkjet printhead die **110** can be the same size, rather than having multiple sized nozzles on inkjet printhead die **110**.

Not shown in FIG. **1**, are the drop forming mechanisms associated with the nozzles. Drop forming mechanisms can be of a variety of types, some of which include a heating element to vaporize a portion of ink and thereby cause ejection of a droplet, or a piezoelectric transducer to constrict the volume of a fluid chamber and thereby cause ejection, or an actuator which is made to move (for example, by heating a bi-layer element) and thereby cause ejection. In any case, electrical pulses from electrical pulse source **16** are sent to the various drop ejectors according to the desired deposition pattern. In the example of FIG. **1**, droplets **181** ejected from the first nozzle array **120** are larger than droplets **182** ejected from the second nozzle array **130**, due to the larger nozzle opening area. Typically other aspects of the drop forming mechanisms (not shown) associated respectively with nozzle arrays **120** and **130** are also sized differently in order to optimize the drop ejection process for the different sized drops. During operation, droplets of ink are deposited on a recording medium **20**.

FIG. **2** shows a perspective of a portion of a printhead **250**, which is an example of the inkjet printhead **100**. Printhead **250** includes three printhead die **251** (similar to printhead die **110** in FIG. **1**) that are affixed to a mounting substrate **255**. Each printhead die **251** contains two nozzle arrays **253**, so that printhead **250** contains six nozzle arrays **253** altogether. The six nozzle arrays **253** in this example are each be connected to ink sources (not shown in FIG. **2**), such as cyan, magenta, yellow, text black, photo black, and protective fluid. Each of the six nozzle arrays **253** is disposed along nozzle array direction **254**, and the length of each nozzle array along the nozzle array direction **254** is typically on the order of 1 inch or less. Typical lengths of recording media are 6 inches for photographic prints (4 inches by 6 inches) or 11 inches for paper (8.5 by 11 inches). Thus, in order to print a full image, a number of swaths are successively printed while moving printhead **250** across the recording medium **20**. Following the printing of a swath, the recording medium **20** is advanced along a media advance direction that is substantially parallel to nozzle array direction **254**.

Also shown in FIG. **2** is a flexible circuit **257** to which the printhead die **251** are electrically interconnected, for example, by wire bonding or TAB bonding. Flexible circuit **257** is also adhered to mounting substrate **255**, and surrounds the printhead die **250** on a printing face **259**. The interconnections are covered by an encapsulant **256** to protect them. Flexible circuit **257** bends around the side of printhead **250** and connects to a connector board **258** on a rear wall **275**. When printhead **250** is mounted into a carriage **200**, connector board **258** is electrically connected to a connector **244** (see FIG. **6**) on the carriage **200**, so that electrical signals can be transmitted to the printhead die **251**.

FIG. **3** shows a portion of a desktop carriage printer. Some of the parts of the printer have been hidden in the view shown in FIG. **3** so that other parts can be more clearly seen. A printer chassis **300** has a platen **301** for supporting recording medium **20** (FIG. **1**) in a print region **303** across which carriage **200** is moved back and forth in a carriage scan direction **305** between a right side **306** and a left side **307** of printer chassis **300**, while drops are ejected from printhead die **251** (not shown in FIG. **3**) on printhead **250** that is mounted on carriage **200**. Paper or other recording medium is held substantially flat against platen **301**. A carriage motor **380** moves a belt **384** to move carriage **200** along a carriage guide **382**. An encoder sensor (not shown) is mounted on carriage **200** and indicates carriage location relative to a linear encoder **383**.

The mounting orientation of printhead **250** is rotated relative to the view in FIG. **2**, so that the printhead die **251** are located at the bottom side of printhead **250** with printing face **259** facing print region **303**, the droplets of ink being ejected downward onto the recording medium (not shown) in print region **303** in the view of FIG. **3**. A multi-chamber ink tank **262**, in this example, contains five ink sources: cyan, magenta, yellow, photo black and colorless protective fluid; while a single-chamber ink tank **264** contains the ink source for text black. Ink tanks **262** and **264** can include electrical contacts (not shown) for data storage devices, for example, to track ink usage. In other arrangements, rather than having a multi-chamber ink tank to hold several ink sources, all ink sources are held in individual single chamber ink tanks.

Paper or other recording medium (sometimes generically referred to as paper or media herein) is loaded along paper load entry direction **302** toward the front of printer chassis **308**. A variety of rollers are used to advance the medium through the printer as shown schematically in the side view of FIG. **4**. In this example, a pick-up roller **320** moves a top piece or sheet **371** of a stack **370** of paper or other recording medium in the direction of arrow, paper load entry direction **302**. A turn roller **322** acts to move the paper around a C-shaped path (in cooperation with a curved rear wall surface) so that the paper continues to advance along a media advance direction **304** from the rear **309** of the printer chassis (with reference also to FIG, **3**). The paper is then moved by a feed roller **312** and idler roller(s) **323** to advance across print region **303** (platen not shown), and from there to a discharge roller **324** and star wheel(s) **325** so that printed paper exits along media advance direction **304**. Feed roller **312** includes a feed roller shaft along its axis, and feed roller gear **311** is mounted on the feed roller shaft. Feed roller **312** can include a separate roller mounted on the feed roller shaft, or can include a thin high friction coating on the feed roller shaft. A rotary encoder (not shown) can be coaxially mounted on the feed roller shaft in order to monitor the angular rotation of the feed roller **312**.

When the piece of medium **371** is in print region **303** below carriage **200**, it can be detected by a carriage sensor **210** that is mounted on carriage **200**. Carriage sensor **210** can be used for detecting surface roughness of the recording medium, side edges of the recording medium, and alignment marks and test patterns printed on the recording medium, for example.

The motor that powers the paper advance rollers is not shown in FIG. **3**, but the hole **310** at the right side of the printer chassis **306** is where the motor gear (not shown) protrudes through in order to engage feed roller gear **311**, as well as the gear for the discharge roller (not shown). For normal paper pick-up and feeding, it is desired that all rollers rotate in forward rotation direction **313**. Toward the left side of the printer chassis **307**, in the example of FIG. **3**, is a maintenance station **330** including a cap **332** and a wiper (not shown).

Toward the rear of the printer chassis **309**, in this example, is located an electronics board **390**, which includes cable connectors **392** for communicating via cables (not shown) to the printhead carriage **200** and from there to the printhead **250**. Also on the electronics board **390** are typically included motor controllers for the carriage motor **380** and for the paper advance motor, a processor and/or other control electronics (shown schematically as controller **14** and image processing unit **15** in FIG. **1**) for controlling the printing process, a clock and an optional connector for a cable to a host computer.

FIG. **5** shows a perspective of a prior art carriage sensor assembly **210** described in U.S. Pat. No. 7,800,089. A frame **211** of carriage sensor **210** can be attached to the outside of side wall **242** (see FIG. **6**) of carriage **200** by bolt **213**, for example. Also shown in carriage sensor assembly **210** are a photosensor **212**, an aperture **214**, a first LED **216** and a second LED **218**. The photosensor **212** and the two LEDs **216** and **218** include semiconductor devices (not shown) that are encapsulated in optically clear materials that form lenses (**215**, **217** and **219** respectively). Lens **215** helps to focus light received through aperture **214** onto the photosensor device, while LEDs **216** and **218** help to direct the emitted light toward the plane of the recording medium. Electrical leads **221**, **222** and **223** from the photosensor **212** and the two LED's **216** and **218** are connected to a wiring board **220**, and from the wiring board **220** to leads (not shown) that can be connected to a carriage electronics board (not shown) that is attached to the carriage **200**. It is preferable for the amplifier circuit to be physically close to the photosensor **212**, because the photosensor output signal is relatively weak and it is important to avoid extraneous electrical noise, for example from printer motor cables, etc. The electronics board **390** attached to carriage **200** can include the electronics for the powering of the LEDs **216** and **218** and for processing the photosensor signal.

FIG. **5** shows an orientation of carriage sensor **210** that is appropriate for a configuration in which the recording medium in the print region **303** is located horizontally below the printhead **250** and the carriage sensor **210** which are mounted on carriage **200**. First LED **216** is oriented to emit light vertically downward along the Z direction, i.e. substantially normal to the XY plane of the recording medium in the print region **303**. In other words, the angle between the orientation of LED **216** and the normal to a plane parallel to the platen **301** is zero. The platen **301** can have regions of recesses as well as a series of protrusions for supporting the paper, but in such a configuration "a plane parallel to the platen" is meant herein to designate a plane that is determined by the surfaces of the protrusions upon which recording medium **20** is intended to be supported. Photosensor **212** is configured to be on one side of first LED **216**, and photosensor **212** is oriented to receive light along a direction that is at an angle of about 45 degrees with respect to the normal Z to the XY plane of the platen **301** (and pointing toward the back of the printer so that it does not receive external stray light). Second LED **218** is configured to be on the other side of first LED **216**, and second LED **218** is oriented to emit light at substantially the same angle with respect to the normal Z, as the photosensor **212**, but on the other side of the normal. In this example, second LED **218** is oriented to emit light along a direction that is around 45 degrees from the normal to the plane of the recording medium **20** in the print region **303**. In other embodiments, the angle between the normal Z and the photosensor **212** on one side and LED **218** on the other side can range between around 30 and 60 degrees, but the angle for each should be the same. Thus, the two LEDs **216**, **218** are configured relative to the photosensor in this carriage sensor

210 such that the photosensor 212 receives specular reflections of light incident on the recording medium 20 from second LED 218, and photosensor 212 receives diffuse reflections of light incident on the recording medium 20 from first LED 216. Photosensor 212 provides an output signal (typically an output current) corresponding to the amount of light that strikes the photosensor 212.

Aperture 214 determines the range of angles of incident light rays that are able to pass to the photosensor 212, while the opaque region around the aperture blocks light rays outside this range of angles. The region of the recording medium 20 that the photosensor 212 "sees" depends not only on the geometry of the aperture 214, but also upon its orientation relative to the plane of the recording medium 20. The use of the aperture 214 enables the use of inexpensive off-the-shelf LEDs 216, 218 and photosensor 212 without requiring special lens designs for those components. In this example, the axis of the aperture 214 is parallel to the axis of the photosensor 212, and both are oriented at an angle with respect to the normal to the platen 301.

FIG. 6 is a perspective of the carriage 200 configured to carry printhead 250 (FIG. 2). Printhead 250 is oriented such that the printhead face 259 (FIG. 2) including printhead die 251 and flex circuit 257 are positioned between flaps 245 when printhead 250 is installed in a holding receptacle 246 of carriage 200. Flaps 245 extend from side walls 242 and 243 of carriage 200 and form a wall 248 facing print region 303 (FIG. 3) when the printhead 250 and carriage 200 are installed in the printer chassis 300. Herein the portion of carriage 200 extending from side walls 242 and 243 and facing print region 303 is called a wall 248, even though it is a discontinuous wall including an opening between adjacent flaps 245 to expose printhead die 251 for printing and flex circuit 257, providing a capping surface for cap 332 (FIG. 3). Connector board 258 of printhead 250 is mated to connector 244 of carriage 200 when printhead 250 is installed. A bushing 241 of carriage 200 is slidably engaged with carriage guide 382 (FIG. 3) in order to provide smooth motion of carriage 200 along carriage scan direction 305. As described above, the prior art carriage sensor 210 was bolted to the outer side of side wall 242.

Embodiments of the present invention provide a more compact carriage sensor than prior art carriage sensor 210. The more compact carriage sensor can be mounted on the wall (such as wall 248) that faces print region 303, rather than being bolted to the outer portion of side wall 242. This can save several millimeters along carriage scan direction 305, so that even in small footprint printers, both side edges of even the widest compatible recording medium in print region 303 can be detected by the carriage sensor described below. Side wall 242 is a first outer wall and side wall 243 is a second outer wall that is separated from the first outer wall of carriage 200 by a carriage width W along carriage scan direction 305 as shown in FIG. 6. The carriage sensor described in U.S. Pat. No. 7,800,089, being bolted to the outer side of side wall 242, is disposed at a distance from the first outer wall (side wall 242) that is less than carriage width W, but it is disposed at a distance from the second outer wall (side wall 243) by a distance that is greater than carriage width W. By contrast, an optical sensor assembly 410 described in an embodiment below is disposed at a first distance from the first outer wall 242 and at a second distance from the second outer wall 243, such that the first distance and the second distance are both less than the carriage width. In addition, assembly is simpler, lower cost and positioning is more accurate, using snap fitting assembly. Wiring is also simplified, using a flexible circuit to mount both LED light sources and the photosensor, rather than having discrete leads 221, 222 and 223 (FIG. 5) connected to a wiring board 220.

A perspective of the optical sensor assembly 410 that can be used as a carriage sensor in embodiments of the invention is shown in FIG. 7. Like the prior art carriage sensor 210, optical sensor assembly 410 is affixed to a carriage 200, the position of which is carefully controlled and monitored with respect to linear encoder 383 (FIG. 3), so that distances (such as those used in measurements of printhead alignment targets, dot placement accuracy, or paper width) can be accurately measured. The optical devices (i.e. the photosensor 212 and LEDs 216, 218) are not readily seen in the view of FIG. 7, being disposed on a mounting member 430 that is within an outer housing 450. The optical devices are electrically connected to a flexible circuit 420 to form a flexible circuit subassembly 421. A connector end 422 of the flexible circuit subassembly 421 extends outwardly from the mounting member 430 and outer housing 450.

A perspective of flexible circuit 420 (rotated relative to FIG. 7 and with mounting member 430 and outer housing 450 hidden) is shown in FIG. 8. A rigid member 423 is attached to flexible circuit 420 at connector end 422 (for support during connecting connector end 422). In addition there are three rigid members 423 at the opposite end of flexible circuit 420, each for providing support to an optical devices (not shown) as described below. Flexible regions 424 between the rigid members (in the region of the optical devices) are bent so that the optical devices can be oriented to detect specular and diffuse reflections as described above relative to prior art carriage sensor 210. A hole 425 is provided as a locating feature for flexible circuit 420.

FIG. 9 shows a close-up underside perspective of flexible circuit 420. A first set of electrical connection pads 426 is provided near hole 425. A second set of electrical connection pads 427 is provided proximate first set of electrical connection pads 426, with a bend disposed in flexible region 424 between the two sets. Similarly, a third set of electrical connection pads 428 is provided proximate second set of electrical connection pads 427, with a bend disposed in flexible region 424 between the two sets. The three rigid members 423 at the optical device mounting end of the flexible circuit 420 are disposed opposite the respective sets of connection pads in order to provide mechanical support for the optical devices to be bonded there. Conductive leads 429 extend from each of the electrical connection pads. There are a total of four leads 429, because one member of each of the three sets 426, 427 and 428 is connected to a common lead.

FIG. 10 shows a perspective similar to that of FIG. 9, but after the optical devices have been attached to flexible circuit 420, thereby forming a flexible circuit subassembly 421. In particular, with reference also to FIG. 9, a photosensor 462 is conductively attached to first set of electrical connection pads 426; first light source (LED) 464 is conductively attached to second set of electrical connection pads 427; and a second light source (LED) 466 is conductively attached to third set of electrical connection pads 428. By providing the bends in flexible regions 424 of flexible circuit 420, an orientation of the first light source 464 is made to be different from an orientation of the second light source 466, and both orientations are different from an orientation of the photosensor 462. In this way, similar to the carriage sensor 210 shown in FIG. 5 and described above, photosensor 462 can sense light emitted from first light source 464 and diffusely reflected from recording medium in print region 303, as well as light emitted from second light source 466 and specularly reflected from recording medium in print region 303. In other embodiments only a single light source **464** or **466** is provided together with photosensor **462** on flexible circuit subassembly **421**.

Orientations of photosensor **462**, first light source **464** and second light source **466** are further established by features of mounting member **430** shown in the perspective of FIG. **11**. Mounting member **430** includes a first cavity **431**, a second cavity **432** and a third cavity **433**. In each of the three cavities **431**, **432** and **433** are shelf-like support features **434** for supporting the photosensor **462**, the first light source **464** and the second light source **466** respectively (FIG. **10**) in their desired orientations. Mounting member **430** also includes a post-like projection **435** for locating the flexible circuit subassembly **421** as shown in FIG. **12** by inserting projection **435** into hole **425**. A first pinching portion **436** is used to pinch a portion of the flexible circuit **420** between mounting member **430** and outer housing **450**.

Mounting member **430** includes an open face **440** (seen more clearly in the bottom perspective shown in FIG. **13**), and a second face **439** that is opposite the open face **440**. Second face **439** is where second cavity **432** is located. When mounting member **430** is installed in carriage **200** in printer chassis **300** (FIG. **3**), open face **440** faces print region **303**. Open face **440** includes a first length L_1 that is along a direction perpendicular to carriage scan direction **305** when mounting member **430** is installed in carriage **200**, which is installed in printer chassis **300** (FIG. **3**). Second face **439** includes a second length L_2 along the direction perpendicular to carriage scan direction **305**. First length L_1 is greater than second length L_2. A first side wall **437** of mounting member **430** extends from open face **440** to second face **439** and includes a first tapered portion **444**. A second side wall **438** is opposite first side wall **437** and includes a second tapered portion **445** (see FIG. **14**) that is opposite first tapered portion **444**.

Included with each of the cavities **431**, **432** and **433** of mounting member **430** is a respective aperture **441**, **442** and **443**, as shown in the bottom perspective of FIG. **13** and the top perspective of FIG. **14**. First aperture **441** determines the field of view of photosensor **462** (not shown in FIG. **13**). Second aperture **442** and third aperture **443** determine optical transmission regions for first light source **464** and second light source **466** respectively. In other words, first aperture **441**, second aperture **442** and third aperture **443** are configured to permit light emitted from the first or second light source (**464** and **466** respectively) and reflected from print region **303** (FIG. **3**) to impinge on photosensor **462**. A second function of apertures **441**, **442** and **443** is to limit the amount of ink mist that is able to land on photosensor **462**, first light source **464** and second light source **466**. As described below, in embodiments of the present invention, the optical sensor assembly **410** is located nearer to the nozzle arrays **253** of an inkjet printhead **250** as compared to carriage sensors of the prior art. The function of limiting mist deposition on the optical devices is an important function of apertures **441**, **442** and **443**.

Also shown in FIG. **13** near the first tapered portion **444** of first side wall **437** of mounting member **430** is a first latching feature **446**. A similar first latching feature **446** is located near the second tapered portion **445** of the second side wall **438** (FIG. **14**). As described below with reference to FIGS. **15** and **16**, the first latching features **446** of the mounting member **430** engage with second latching features **456** of outer housing **450** when mounting member **430** is snap fitted into outer housing **450**.

FIG. **15** shows outer housing **450** from a perspective showing that outer housing **450** has a similar trapezoidal shape as mounting member **430** (FIG. **11**). Outer housing **450** includes an open portion **455** that is located near open face **440** (FIG. **13**) of mounting member **430** when outer housing **450** is assembled onto mounting member **430**. With reference also to FIG. **13**, outer housing **450** includes a first housing side wall **457** that is adjacent first side wall **437** of mounting member **430** and a second housing side wall **458** that is adjacent to second side wall **438** of mounting member **430** when the outer housing is assembled onto mounting member **430**. To facilitate snap fitting of mounting member **430** into outer housing **450**, first housing side wall **457** and second housing side wall **458** are configured to be outwardly deformable. Windows **451** provide additional flexibility to the first and second housing side walls **457** and **458**. With reference also to the bottom end perspective of FIG. **16**, wedge-shaped second latching features **456** on first and second housing side walls **457** and **458** are provided to engage with first latching features **446** on mounting member **430** (FIG. **13**). As described below, as the first and second tapered portions **444** and **445** of first and second side walls **437** and **438** of mounting member **430** are slidingly moved past wedge-shaped second latching features **456** of outer housing **450**, first and second housing side walls **457** and **458** are outwardly deformed until first latching features **446** have been moved past second latching features **456** and into engagement as the first and second housing side walls **457** and **458** snap back into their original undeformed shapes. With reference also to FIG. **15**, second pinching portion **453** is provided on outer housing **450** in order to pinch a portion of flexible circuit **420** against a first pinching portion **436** of mounting member **430**, thereby providing strain relief. Also included on outer housing **450** is recess **454** in order to accommodate projection **435** of mounting member **430** (FIG. **12**), as mounting member **430** is inserted into outer housing **450**.

FIG. **17** shows a perspective of optical sensor assembly **410**, where flexible circuit **420** extends from the outer housing **450** and mounting member **430**. In this example, additional bends have been made in flexible regions **424** near connector end **422** of flexible circuit **420**, as well as near outer housing **450**. Such bends can be useful for positioning connector end **422** such that it can be electrically connected to a carriage electronics board (not shown) on carriage **200**.

FIG. **18** shows a top perspective of carriage **200** with optical sensor assembly **410** disposed next to outer side wall **242**, between outer side walls **242** and **243** of carriage frame **201**. Outer side wall **242** is separated from outer side wall **243** by a carriage width W along carriage scan direction **305**. Optical sensor assembly **410** is disposed on carriage **200** at a first distance from outer side wall **242** and at a second distance from outer side wall **243**, such that both the first distance and the second distance are less than carriage width W. With reference also to FIG. **3**, the wall facing print region **303** when carriage **200** is installed in printer chassis **300** (with bushing **241** slidably mounted on carriage guide **382**) is wall **248**.

FIG. **19** shows a bottom perspective and FIG. **20** shows a bottom view of carriage **200** with optical sensor assembly **410** disposed within wall **248** between side walls **242** and **243**. Open face **440** of optical sensor assembly **410**, like wall **248**, faces print region **303** (FIG. **3**) when carriage **200** is installed in printer chassis **300**. In FIG. **19**, flexible circuit **420** is shown in the bent configuration of FIG. **17** for connection to a carriage electronics board (not shown) mounted on a carriage frame **201**. FIG. **21** shows an enlarged bottom view of a portion of carriage **200**, also showing three printhead die **251** with six nozzle arrays **253** and printhead flexible circuit **257** located on a printing face **259** between outer side wall **242** and outer side wall **243**. Nozzle arrays **253** are portions of drop ejector arrays that are examples of marking elements included in printhead **250** (FIG. **2**). A dashed line **280** indicates a center of the plurality of arrays of marking elements (i.e. a center of the six nozzle arrays **253**). Carriage **200** includes a carriage width W along carriage scan direction **305**. Optical sensor assembly **410** is disposed on carriage **200** at a predetermined separation S from the center **280** of the plurality of arrays of marking elements, such that S is less than half the carriage width W. In some embodiments, the outer housing **450** of optical sensor assembly **410** is integrated as part of carriage **200**, rather than being a discrete part that is subsequently mounted to carriage **200**.

Having described the structural elements of optical assembly **410**, carriage **200** and carriage printer chassis **300**, embodiments of assembly methods will now be described with reference to FIGS. **3** and **7-21**. Embodiments are described relative to optical sensor assemblies **410** including one or two light sources. A flexible circuit subassembly **421** including the photosensor **462** and at least one light source **464** or **466** is provided. The mounting member **430** including the first cavity **431** and at least a second cavity **432** or **434** is provided such that the second cavity **432** or **433** has an orientation that is different than an orientation of the first cavity **431**. Mounting member **430** can be formed by injection molding, for example. Flexible circuit subassembly **421** is mounted on mounting member **430** such that the photosensor **462** is disposed in the first cavity **431** and light source **464** or **466** is disposed with second cavity **432** or **433**. Mounting member **430** is affixed to an outer housing **450**, such that a connector end **422** of flexible circuit subassembly extends outwardly from mounting member **430** and outer housing **450**.

In providing flexible circuit subassembly **421**, photosensor **462** can be conductively bonded (for example by solder bonding) to the first set of electrical connection pads **426** on the flexible circuit **420**. Similarly light source **464** is conductively bonded to the second set of electrical connection pads **427**, and optionally an additional light source **466** is conductively bonded to the third set of electrical connection pads **428**.

Mounting flexible circuit subassembly **421** on mounting member **430** can include engaging a locating feature (such as hole **425**) in flexible circuit **420** with a corresponding locating feature (such as projection **435**) of mounting member **430**. In particular, projection **435** can be inserted into hole **425** and the flexible circuit subassembly **421** can then be wrapped on mounting member **430**, bending flexible region(s) **424** at locations between photosensor **462** and first light source **464**, and optionally also between first light source **464** and second light source **466**. Photosensor **462** is placed within first cavity **431** and a first light source **432** is placed within the second cavity **432**. In some embodiments a second light source **433** is placed within the third cavity **433**.

Mounting member **430** is then affixed to outer housing **450** such that a portion of flexible circuit subassembly **421** is pinched between outer housing **450** and mounting member **430** in order to provide strain relief. Affixing the mounting member **430** to outer housing **450** can include snap fitting. During **25**, snap fitting, a pair of opposing walls (first housing side wall **457** and second housing side wall **458**) are outwardly deformed. In particular, as mounting member **430** is inserted into outer housing **450**, a pair of tapered portions **444** and **445** of side walls **437** and **438** is pushed into slidable contact with wedge-shaped second latching features **456** on each of the pair of housing side walls **457** and **458**. As mounting member **430** is pushed further into outer housing **450**, first and second housing side walls **457** and **458** are deformed outwardly until first latching features **446** move past second latching features **456**, permitting first and second housing side walls **457** and **458** to snap back into their original positions and latch mounting member **430** into position.

Assembling carriage printer chassis **300** can include providing the platen **301** to support print media within a print region; providing the carriage guide **382** extending parallel to platen **301**, providing the carriage **200** including the carriage frame **201** having a portion (such as wall **248**) configured to be proximate the printing face **259** of the printhead **250**; affixing the optical sensor assembly **410** to the portion (such as wall **248**) configured to be proximate the printing face **259** of the printhead **250**; and slidably mounting the carriage frame **201** (at bushing **241**) onto carriage guide **382**, such that the portion (wall **248**) of carriage frame **201** faces platen **301**. In some embodiments, outer housing **450** is injection molded as part of carriage frame **201**. Connector end **422** of flexible circuit subassembly **421** is connected to a carriage electronics board (not shown) that is affixed to carriage frame **201**.

In addition to the advantages of optical sensor assembly **410** described above (including compactness, low cost assembly, and more accurate positioning), a further advantage is improved optical efficiency. Optical sensor assembly **410** can be mounted significantly closer to print region **303** than prior art carriage sensor **210**. Since light intensity is inversely proportional to the square of the distance, the closer positioning results in improved optical efficiency,

The invention has been described in detail with particular reference to certain preferred embodiments thereof, but it will be understood that variations and modifications can be effected within the spirit and scope of the invention.

PARTS LIST

10 Inkjet printer system
12 Image data source
14 Controller
15 Image processing unit
16 Electrical pulse source
18 First ink source
19 Second ink source
20 Recording medium
100 Inkjet printhead
110 Inkjet printhead die
111 Substrate
120 First nozzle array
121 Nozzle(s)
122 Ink delivery pathway (for first nozzle array)
130 Second nozzle array
131 Nozzle(s)
132 Ink delivery pathway (for second nozzle array)
181 Droplet(s) (ejected from first nozzle array)
182 Droplet(s) (ejected from second nozzle array)
200 Carriage
201 Carriage frame
210 Carriage sensor
211 Frame of carriage sensor assembly
212 Photosensor
213 Bolt
214 Aperture
215 Photosensor lens
216 LED mounted for diffuse reflections
217 LED lens
218 LED mounted for specular reflections
219 LED lens
220 Wiring board
221 Photosensor electrical leads
222 LED electrical leads
223 LED electrical leads

241 Bushing
242 Side wall
243 Side wall
244 Connector
245 Flap
246 Holding receptacle
248 Wall (facing print region)
250 Printhead
251 Printhead die
253 Nozzle array
254 Nozzle array direction
255 Mounting substrate
256 Encapsulant
257 Printhead flexible circuit
258 Connector board
259 Printing face
262 Multichamber ink tank
264 Single chamber ink tank
275 Rear wall
280 Center of arrays of marking elements
300 Printer chassis
301 Platen
302 Paper load entry direction
303 Print region
304 Media advance direction
305 Carriage scan direction
306 Right side of printer chassis
307 Left side of printer chassis
308 Front of printer chassis
309 Rear of printer chassis
310 Hole (for paper advance motor drive gear)
311 Feed roller gear
312 Feed roller
313 Forward rotation direction (of feed roller)
320 Pick-up roller
322 Turn roller
323 Idler roller
324 Discharge roller
325 Star wheel(s)
330 Maintenance station
332 Cap
370 Stack of media
371 Top piece of medium
380 Carriage motor
382 Carriage guide
383 Linear encoder
384 Belt
390 Printer electronics board
392 Cable connectors
410 Optical sensor assembly
420 Flexible circuit
421 Flexible circuit subassembly
422 Connector end
423 Rigid member
424 Flexible region
425 Hole
426 First set of electrical connection pads
427 Second set of electrical connection pads
428 Third set of electrical connection pads
429 Lead
430 Mounting member
431 First cavity
432 Second cavity
433 Third cavity
434 Support feature
435 Projection
436 First pinching portion
437 First side wall
438 Second side wall
439 Second face
440 Open face
441 First aperture
442 Second aperture
443 Third aperture
444 First tapered portion
445 Second tapered portion
446 First latching feature
450 Outer housing
451 Window(s)\
453 Second pinching portion
454 Recess
455 Open portion
456 Second latching feature
457 First housing side wall
458 Second housing side wall
462 Photosensor
464 First light source
466 Second light source

The invention claimed is:

1. A method of assembling an optical sensor assembly for a carriage of a carriage printer, the method comprising:

providing a flexible circuit subassembly including a photosensor and a light source;

providing a mounting member including a first cavity and a second cavity having an orientation that is different than an orientation of the first cavity;

mounting the flexible circuit subassembly on the mounting member such that the photosensor is disposed in the first cavity and the light source is disposed in the second cavity; and

affixing the mounting member to an outer housing, wherein a connector end of the flexible circuit subassembly extends outwardly from the mounting member and the outer housing; wherein mounting the flexible circuit subassembly on the mounting member includes bending a flexible region of the flexible circuit assembly at a location between the photosensor and the light source.

2. The method according to claim **1**, wherein providing the mounting member includes injection molding the mounting member.

3. The method according to claim **1**, wherein mounting the flexible circuit subassembly on the mounting member includes engaging a locating feature of the flexible circuit subassembly with a corresponding locating feature of the mounting member.

4. The method according to claim **3**, wherein engaging the locating feature of the flexible circuit subassembly with the corresponding locating feature of the mounting member includes inserting a projection of the mounting member into an alignment hole of the flexible circuit subassembly.

5. The method according to claim **1**, wherein affixing the mounting member to the outer housing includes snap fitting the mounting member into the outer housing.

6. The method according to claim **5**, wherein snap fitting the mounting member into the outer housing includes outwardly deforming a pair of opposing walls of the outer housing.

7. The method according to claim **6**, wherein outwardly deforming a pair of opposing walls of the outer housing includes inserting the mounting member into the outer housing such that a pair of tapered portions of side walls of the mounting member is pushed into slidable contact with wedge shaped features on each of the pair of opposing side walls of the outer housing.

8. A method of assembling an optical sensor assembly for a carriage of a carriage printer, the method comprising:

providing a flexible circuit subassembly including a photosensor and a light source;

providing a mounting member including a first cavity and a second cavity having an orientation that is different than an orientation of the first cavity;

mounting the flexible circuit subassembly on the mounting member such that the photosensor is disposed in the first cavity and the light source is disposed in the second cavity; and

affixing the mounting member to an outer housing, wherein a connector end of the flexible circuit subassembly extends outwardly from the mounting member and the outer housing; wherein providing the flexible circuit subassembly includes:

providing a flexible circuit including a first set of electrical connection pads and a second set of electrical connection pads;

conductively bonding the photosensor to the first set of electrical connection pads; and

conductively bonding the light source to the second set of electrical connection pads.

9. A method of assembling an optical sensor assembly for a carriage of a carriage printer, the method comprising:

providing a flexible circuit subassembly including a photosensor and a light source;

providing a mounting member including a first cavity and a second cavity having an orientation that is different than an orientation of the first cavity;

mounting the flexible circuit subassembly on the mounting member such that the photosensor is disposed in the first cavity and the light source is disposed in the second cavity; and

affixing the mounting member to an outer housing, wherein a connector end of the flexible circuit subassembly extends outwardly from the mounting member and the outer housing; wherein affixing the mounting member to the outer housing includes pinching a portion of the flexible circuit subassembly between the outer housing and the mounting member.

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